

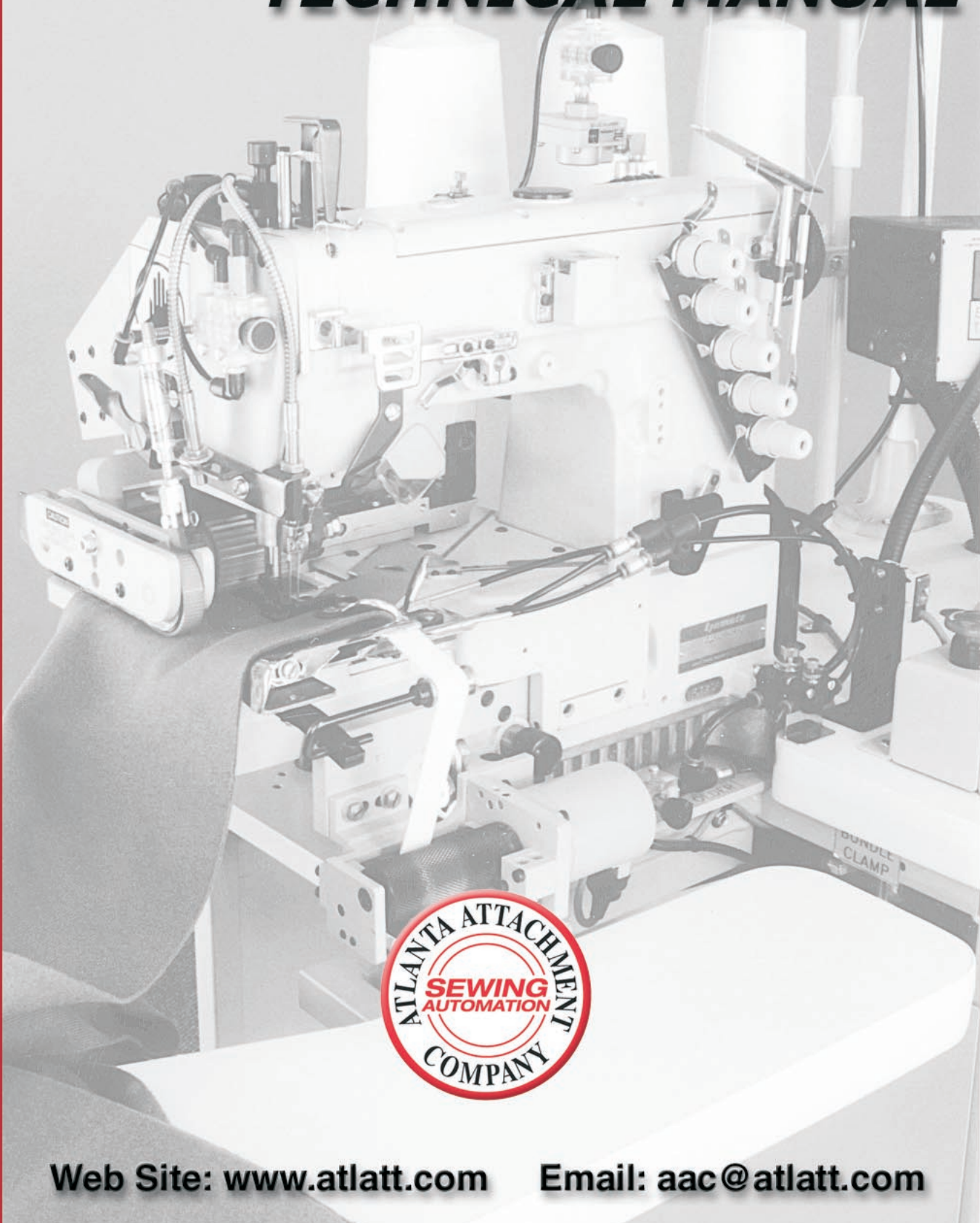
*Innovative Technology For The Sewn Products Industry World Wide*

ATLANTA ATTACHMENT

# **1536A**

***Automatic Elastic Leg Unit***

## **TECHNICAL MANUAL**



**Web Site: [www.atlatt.com](http://www.atlatt.com)**

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# **TECHNICAL MANUAL ZZ1536A**

## **LISTS OF PARTS AND DIAGRAMS**

**FOR  
11536A  
AUTO LEG UNIT**

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**LAWRENCEVILLE, GA.  
(770)963-7369 FAX(770)963-7641**

**PRINTED IN THE U.S.A.**

# **MANUAL TÉCNICO ZZ1536A**

## **LISTAS DE PARTES Y DIAGRAMAS**

**PARA LA  
ESTACIÓN AUTOMÁTICA  
11536A  
PARA PEGAR ELÁSTICOS A  
PERNERAS**

**DERECHOS DE AUTOR© 2001  
POR**

**ATLANTA ATTACHMENT  
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**POR  
ATLANTA ATTACHMENT  
CO., INC.**

**LAWRENCEVILLE, GA.  
(770)963-7369 FAX(770)963-7641**

**IMPRESO EN EE.UU.**

**This equipment is protected by one or more of the  
following patents:**

US patents - 4,038,933; 4,280,421; 4,432,294; 4,466,367;  
4,644,883; 4,886,005; 5,134,947; 5,159,889; 5,203,270;  
5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563;  
5,562,060; 5,634,418; 5,647,293; 5,657,711; 5,743,202. Foreign  
patents - 2,084,055; 2,076,379; 2,177,389; 2,210,569;  
4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6;  
95,935,082.8; 96,936,922.2; 5,865,135.

Other U.S. and Foreign Patents Pending.  
1998 Atlanta Attachment Company.

**Este equipo es fabricado bajo una o más de las  
patentes siguientes:**

En E.U.- 4,038,933; 4,280,421; 4,432,294; 4,466,367;  
4,644,883; 4,886,005; 5,134,947; 5,159,889; 5,203,270;  
5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563;  
5,562,060; 5,634,418; 5,647,293; 5,657,711; 5,743,202.  
En El extranjero - 2,084,055; 2,076,379; 2,177,389; 2,210,569;  
4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6;  
95,935,082.8; 96,936,922.2; 5,865,135.

Otras patentes pendientes en los EE.UU. y el exterior.  
Atlanta Attachment Company 1998

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### DESCRIPTION

An electro-pneumatic device consisting of a variable speed puller, an impact type cutter controlled by a single retro-reflective eye, and a belt conveyor positioned to the side of the presser foot. This unit is designed to automatically cut raw rubber or narrow elastic between garment parts such as sweat pant legs. Automatic start and stop control reduces waste between pieces.

### DESCRIPCIÓN

Un aparato electro-neumático que consiste de un rodillo de velocidad variable, una cortadora de impacto controlada por un ojo electrónico y una cinta transportadora situada al lado del prensatelas. Diseñada para cortar automáticamente goma cruda o elástico angosto entre partes de prendas tales como perneras de sudaderas. El control automático de comenzar y parar reduce desperdicio entre piezas.

## Machine Start/Stop Timing Adjustments

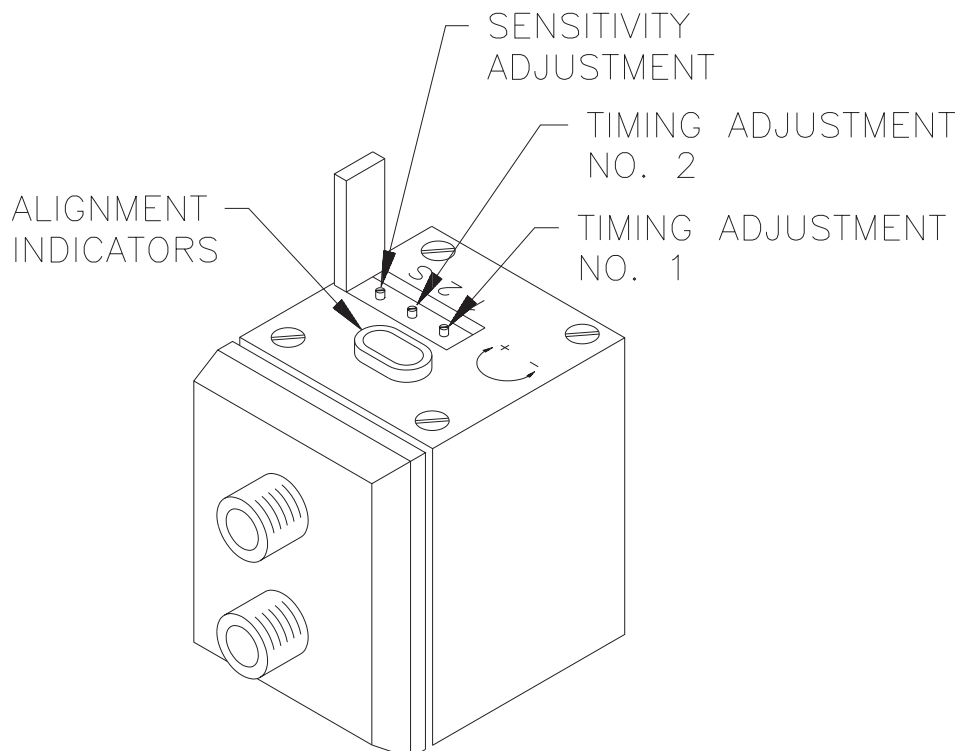
1. Look for the set screw labeled "1,2,S" in the small window located on the side of the machine eye control box.
2. Turn all three set screws counter-clockwise until you hear a small "click". This may require several turns.
3. Screw "1" will adjust the delay of when the machine will stop after the garment passes through the folder. The machine should stop when the garment is approximately 1/2" behind the foot.
4. Screw "2" will adjust the delay of when the machine will run automatically from the time the electric eye is covered by the leading edge of the garment.
5. Screw "S" will adjust the sensitivity of the eye. Turn this screw until the green light comes on, then turn the screw one more complete turn.

**Note:** Before adjusting the screws listed above, make sure the reflective tape the eye is looking at is in good condition.

## Ajuste del tiempo de Comenzar/Parar de la máquina.

1. Encuentre el tornillo de presión rotulado "1,2, S" en la ventanilla pequeña situada en el lado de la caja del control del ojo de la máquina.
2. Dele vuelta a los tres tornillos en el sentido contrario a las manecillas hasta que Ud. oye un pequeño "click". Esto puede requerir varias vueltas.
3. El Tornillo "1" ajustará el retardo de cuando la máquina parará después que la pieza pase a través del plegador. La máquina debe parar cuando la pieza esté aproximadamente 1/2" detrás del pie.
4. El Tornillo "2" ajustará el retardo de cuando la máquina funcionará automáticamente desde que el ojo eléctrico es cubierto por el borde delantero de la pieza.
5. El Tornillo "S" ajusta la sensibilidad del ojo. Dele vuelta a este tornillo hasta que la luz verde se enciende, después le da una vuelta completa más.

**Nota:** Antes de ajustar los tornillos mencionados, asegúrese que cinta reflectora a la que el ojo está dirigido se encuentra en buenas condiciones.





## Cutter Timing Adjustments

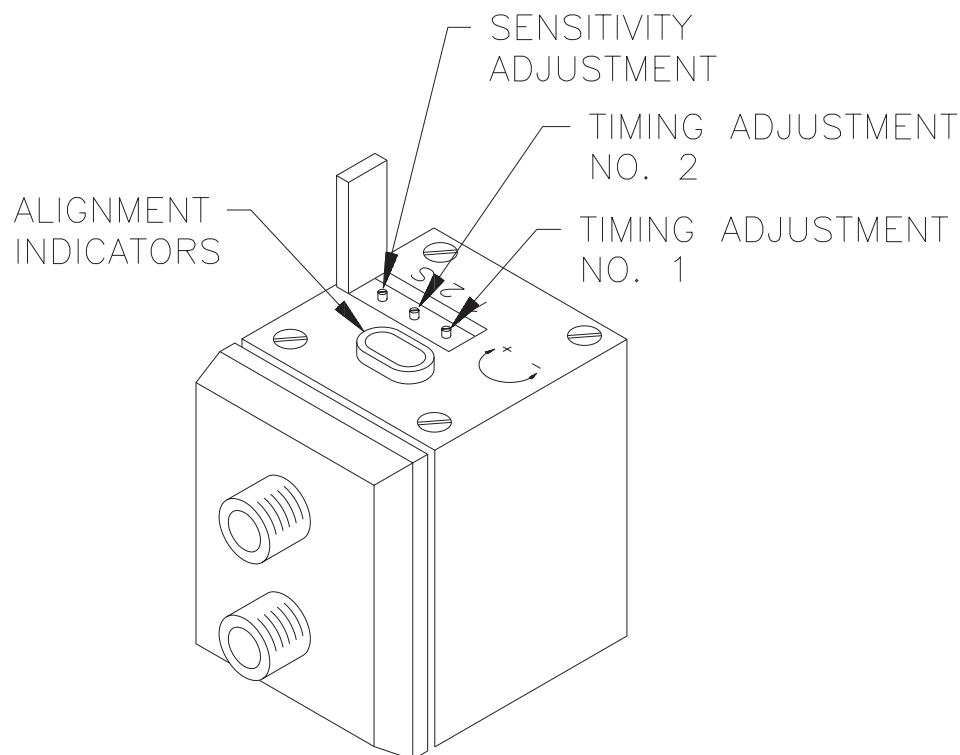
1. Look for the set screw labeled "1,2,S" in the small window located on the side of the Cutter eye control box.
2. Turn all three set screws counter-clockwise until you hear a small "click". This may require several turns.
3. Screw "1" adjusts the timing of when the Cutter will activate from the time the electric eye is covered by the leading edge of the garment.
4. Screw "2" adjusts the length of the cut signal. This setting is normally adjusted until the Cutter cylinder makes a good positive stroke. It should rarely need to be adjusted.
5. Screw "S" adjusts the sensitivity of the eye. Because of the type of eye, this screw should not need to be adjusted.

**Note:** Before adjusting the screws listed above, make sure the reflective tape the eye is looking at is in good condition.

## Ajuste del tiempo de la Cuchilla

1. Encuentre el tornillo de presión rotulado "1,2, S" en la ventanilla pequeña situada en el lado de la caja del control del ojo de la cuchilla.
2. Dele vuelta a los tres tornillos en el sentido contrario a las manecillas del reloj hasta que Ud. oye un "click". Esto puede requerir varias vueltas.
3. El Tornillo "1" ajusta el retardo de cuando la cuchilla comienza después que el ojo es cubierto por el borde delantero de la pieza.
4. El Tornillo "2" ajusta el largo de la señal de cortar. Normalmente se ajusta hasta cuando el cilindro de la cuchilla dá un golpe completo. Raramente nesecita ser ajustado.
5. El Tornillo "S" ajusta la sensibilidad del ojo. Deibido al la clase de ojo, este tornillo no nesecita ser ajustado.

**Nota:** Antes de ajustar los tornillos mencionados, asegurese que cinta reflectora a la que el ojo está dirigido se encuentra en buenas condiciones.



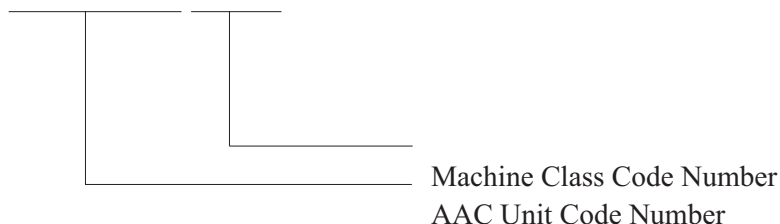
## Configurations

**The 11536A comes in the following configuration.**

A cylinder arm Coverstitch Sewing Head, Power Console, Electronic Controls, Electric Motor, Electronic Metering Device, Puller with Side Conveyor, Cut Apart Cutter, Bundle Clamp and Table and Automatic Start/Stop Feature.

**The Atlanta Attachment's Auto Leg Elastic Units Numbers are made in the following manner.**

### 11536AXXX



### Sewing Machine Codes

Y37  
R62

YAMATO 2640P  
RIMOLDI F71112

## Part List Directions

**The following pages contain the appropriate assembly drawings for this unit.**

***Las páginas siguientes contienen los dibujos de los ensamblados que hacen parte de esta unidad.***

Below is a brief description of the Atlanta Attachment parts list and how to use it.

*Debajo hay una descripción de la lista de partes de Atlanta Attachment y como usarla.*

Part No.	Description	Qty.	Pg.
1	010-047	Belt Idler Assembly	1 30

A further break down of the item in question can be found on the page listed

*Manifiesta sub-división del artículo en cuestión en ésta página.*

This is the quantity of this part no. that was originally used in the assembly process. A "0" denotes an optional item.

*Muestra la cantidad de ésta parte. Un "0" denota que es una parte opcional.*

A brief description of the part to aid in identifying it on the drawing. When ordering spare parts be sure to use the part no. as this is how AAC stocks parts.

*Breve descripción de la parte para mejor identificación en el dibujo. Cuando ordene repuestos utilice el número de la parte.*

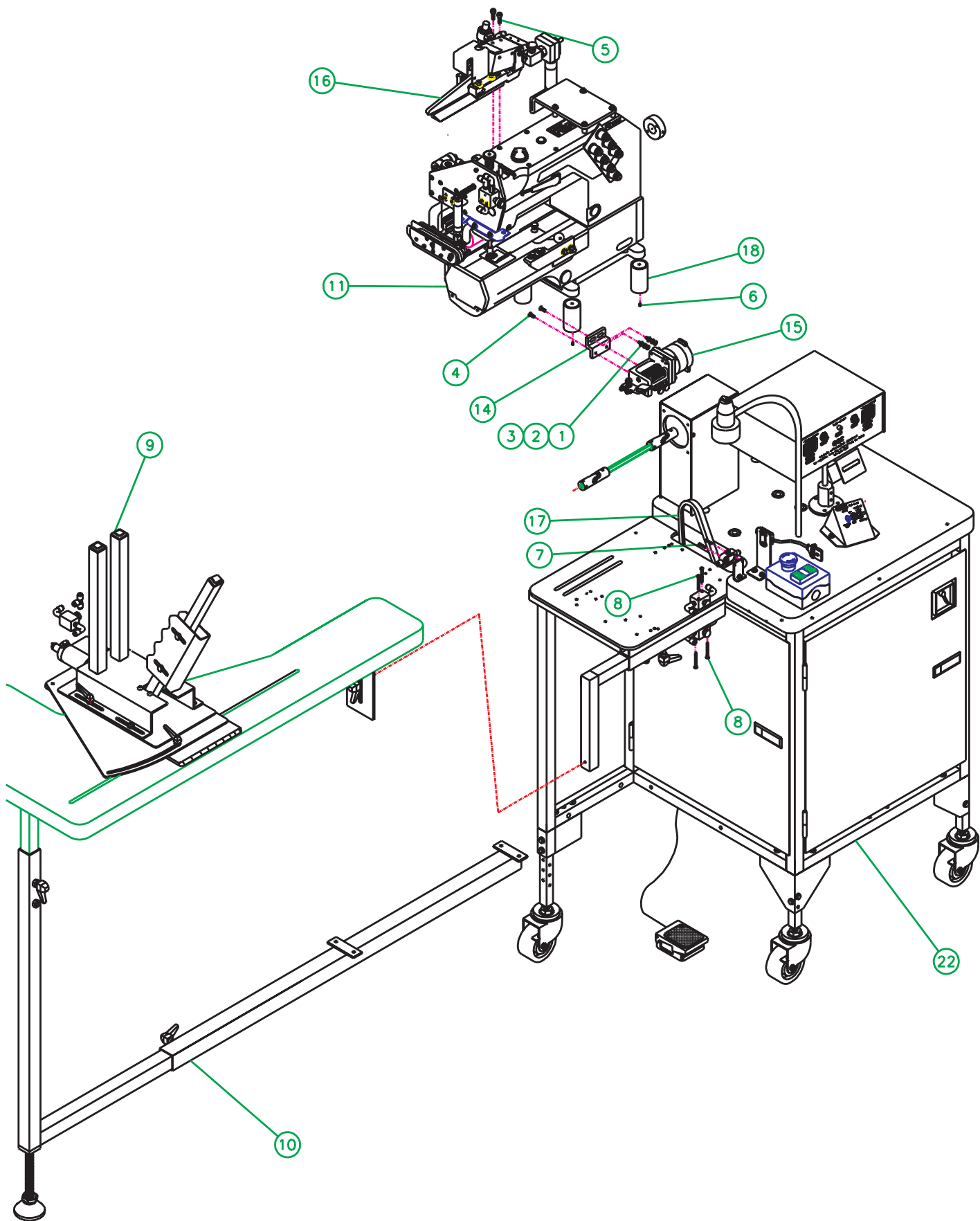
The Atlanta Attachment Company part number. Be sure to reference this number when ordering spares.

*Este es el número de la parte de la Compañía Atlanta Attachment. Siempre utilice éste número cuando ordene repuestos.*

Refers to the number in the bubble on the drawing. A number including a decimal denotes a part of a sub-assembly. Example 26.1 is part of sub-assembly 26.

A hexagonal bubble denotes connecting parts.

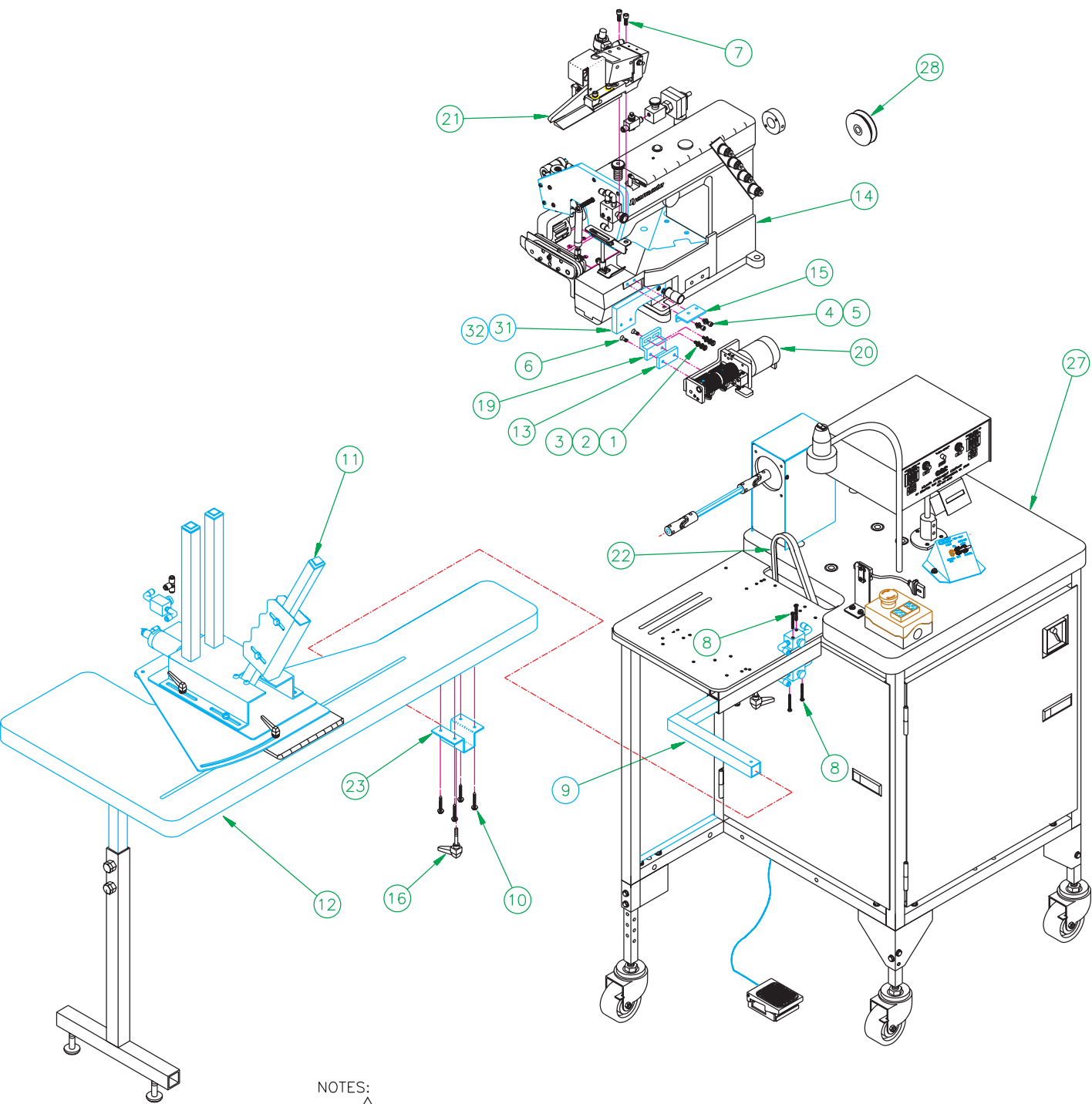
*Se refiere al número de la parte en el dibujo. Un número que incluye decimales quiere decir que es parte de un sub-ensamblado. Por ejemplo 26.1 hace parte del ensamblado número 26. Los números en exágonos denotan partes que se conectan.*





## 11536AR62 Auto Elastic Stand Up

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	SSM627A	Scr,Hx Sl .214x32x13/16	2	18	26281	Isolator	4
2	WWL1/4	1/4 Lock Washer	2	19	1536INS1	Machine Start/Stop	1 4
3	WWFS1/4	Flat Washer, 1/4	2	20	1536INS2	Cutter Timing	1 5
4	SSFC98032	Scr,Fl Al Cp 10-32x1/2	2	21	AP-28LBINS	AP-28 Instruction	1 41
5	SSSC98048	Scr,So Cp 10-32x3/4	2	22	1536-100	Power Console	1 25
6	SSSS01032	Scr,St,Knr 1/4-20x1/2	4	23	4059-PM63	Pulley, Efka Motor	1
7	SSPS80048	Scr,Pn Hd Sl 6-32x3/4	2	24	1536INS6	Instructions 1536	1
8	SSPS80080	Scr,Pn Hd Sl 6-32x1 1/4	4	*25	1536INS3	Instruction Moving	0
9	11743D	Bundle Clamp	1 13	*26	1536INS4	Instruction Replacing	0
10	11745B	Bundle Table	1 14	*27	1536INS5	Instructionc Changing	0
11	1535PA-R62	Sewing Head Assembly	1 35	*28	1536-070	Eye Bracket	0
12	1536APD	Pneumatic Diagram	1 30	*29	1536-071	Eye Bracket Mount	0
13	1536AWD	Wiring Diagram	1 31	*30	4048-7B	Work Suface Table	0
14	28206	Head Mount	1	*31	1536-EFKA	Cable Package	1
15	28M-100	Met Hd H/S	1 17	* = Optional			
16	AAT404	4" Cutter	1 21	AAC Drawing Number - 191210C Rev. 5			
17	ZX3833	V Belt	1				

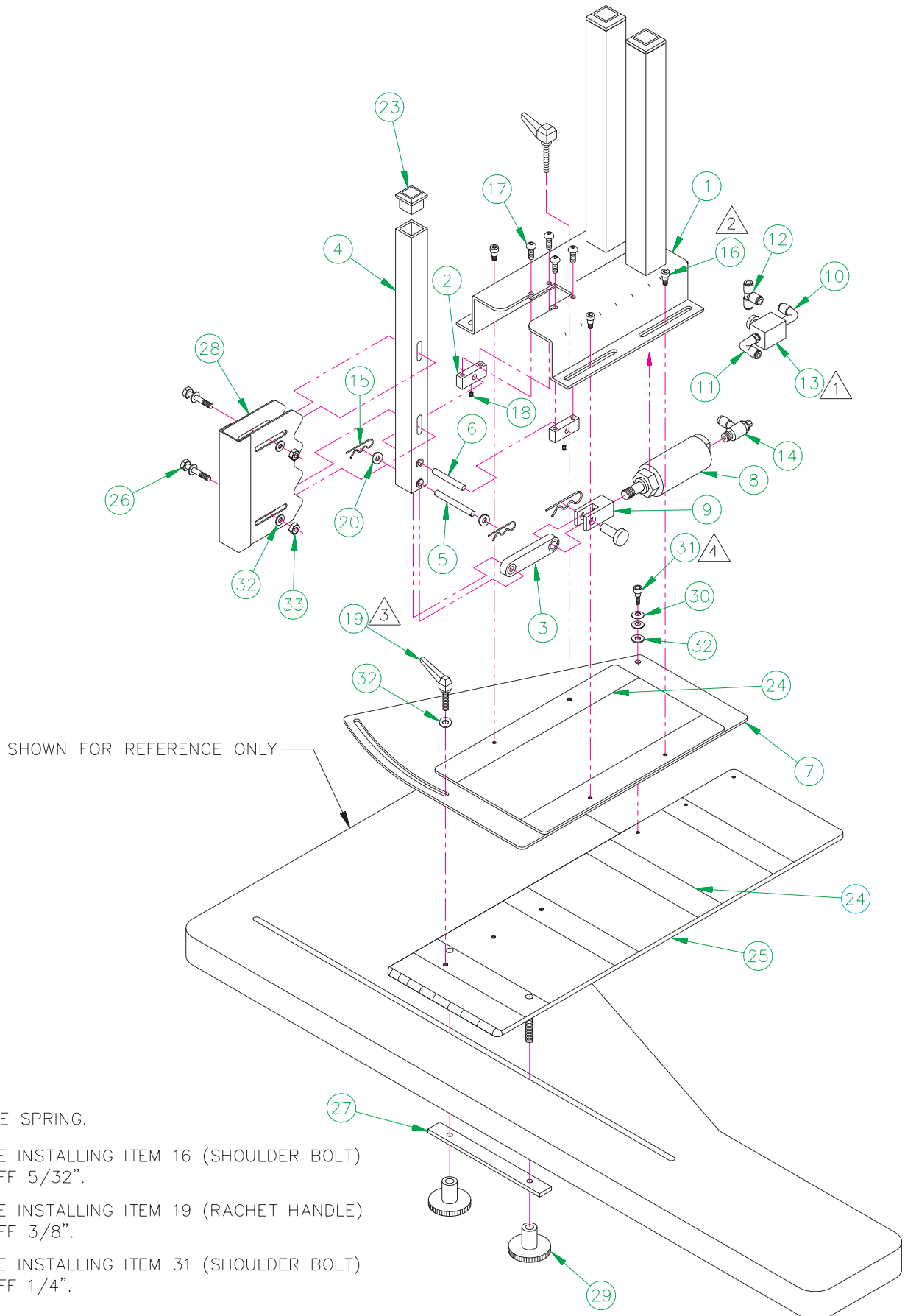


NOTES:  
1 NOT SHOWN.

## 11536AY37 Auto Elastic Stand Up, Double Puller

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	SSM627A	Scr,Hx Sl .214-32x13/16	2	17	1536APD	Pneumatic Diagram	1 30
2	WWL1/4	1/4 Lock Washer	2	18	1536AWD	Wiring Diagram	1 31
3	WWFS1/4	Flat Washer 1/4	2	19	28206	Head Mount	1
4	SSSCM4X16M	Scr,So Cp 4mx.7x16mm	2	20	350-5600A	Elastic Metering	1 19
5	WWF8	Flat Washer	2	21	AAT304	3" Cutter	1 23
6	SSFC98048	Scr,Fl Al Cp 10-32x3/4	2	22	ZX3832	V Belt	1
7	SSSC98048	Scr,So Cp 10-32x3/4	2	23	23532	Hor Sleeve Assembly	1
8	SSPS80080	Scr,Pn Hd Sl 6-32x1 1/4	4	24	1536INS1	Mach Start/Stop	1 4
9	26161	Adjustment Tube	1	25	1536INS2	Cutter Timing	1 5
10	SSZH#10064	Scr,Sh Me Hx #10x1	4	26	AP-28LBINS	AP-28 Instructions	1 41
11	11743D	Bundle Clamp	1 13	27	1536-100	Power Console	1 25
12	11745D	Bundle Table	1 15	28	4059-PM71	Pulley, Efka Motor	1
13	1535-402	Spacer Met Head	1	29	353-23-8	Folder	1 Δ1
14	1535PA-Y37	Sewing Head Assembly	1 37	30	1536-EFKA	Cable Package	1 Δ1
15	1536-037	Folder Mount	1	31	SSSCM6X16	Scr,So Cp M6x1x16mm	2
16	TTH32415	Threaded Handle	1	32	1536-038	Metering Dev. Bracket	1

AAC Drawing Number = 191062C Rev. 11



## NOTES:

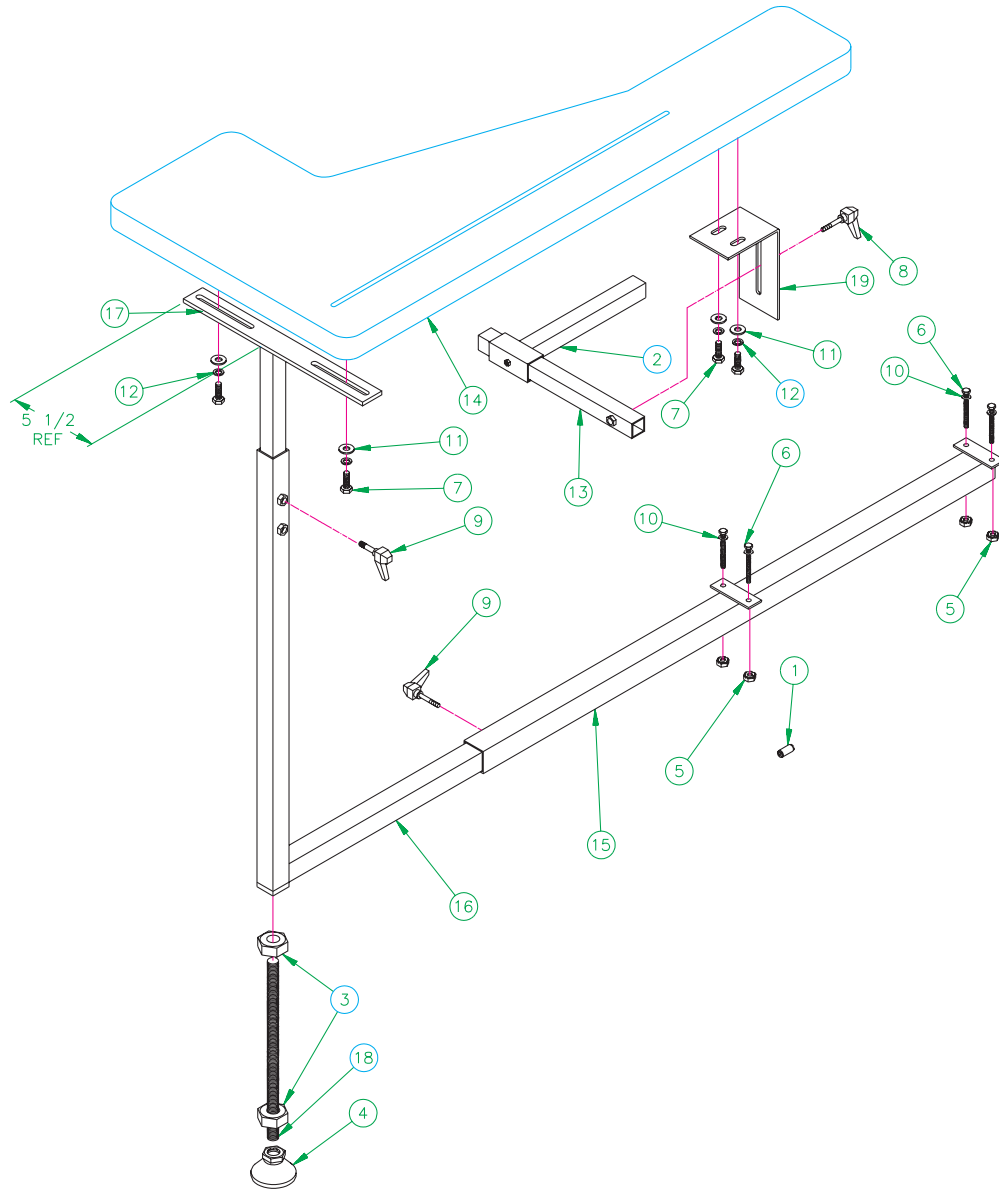
- 1 REMOVE SPRING.
- 2 BEFORE INSTALLING ITEM 16 (SHOULDER BOLT) CUT OFF 5/32".
- 3 BEFORE INSTALLING ITEM 19 (RACHET HANDLE) CUT OFF 3/8".
- 4 BEFORE INSTALLING ITEM 31 (SHOULDER BOLT) CUT OFF 1/4".

## 11743D Bundle Clamp, Pneumatic Pivot

See Pgs. 9 and 11

No.	Part No.	Description	Qty.	Pg.No.	Part No.	Description	Qty.	Pg.
1	1743-001	Housing	1		18	SSSS98016	Scr,So St 10-32x1/4	2
2	1743-003	Trunion Half	2		19	TTH32415	Threaded Handle	2
3	1743-004	Link, Air Cylinder	1		20	WWF10	#10 Flat Washer	2
4	1743-017	Tube, Clamp	1		21	AATP5/32	5/32 Air Line	6ft
5	1743-006	Shaft, Lower	1		22	AATP4-1	1/4 Air Line	6ft
6	1743-007	Shaft, Upper	1		23	MM132-1202	Square End Cap	3
7	1743-012	Pivot Plate	1		24	MM130-10A	Teflon Tape	29"
8	AAC5S-1	Air Cylinder	1		25	1743-013B	Mount Plate	1
9	AAFCT-15	Clevis	1		26	SSHC01080	Scr,Hx Cp 1/4-20x1 1/4	2
10	AAQME-4-8	Quick Male Elbow	1		27	1743-015	Washer Plate	1
11	AAQME-5-8	Quick Male Elbow	1		28	1743-016	Weld, Grip Bracket	1
12	AAQUT-4-4	Quick Union T	1		29	MM697830	Plastic Knob	2
13	AAVMB32	Switch	1		30	WWS307-1	Spring Washer	2
14	AA198RR508	Reverse Flow Control	1		31	SSAS016016	Scr,Al Sh 1/4-1/4	1
15	MM98335A04	Cotter Dey	2		32	WWF1/4	Washer, 1/4	6
16	SSAS016012	Scr,Al Sh 1/4x3/16	3		33	NNH1/4-20	Nut, Hex	2
17	SSBC98040	Scr,But Cp 10-32x5/8	4		AAC Drawing Number 191404C Rev. 0			

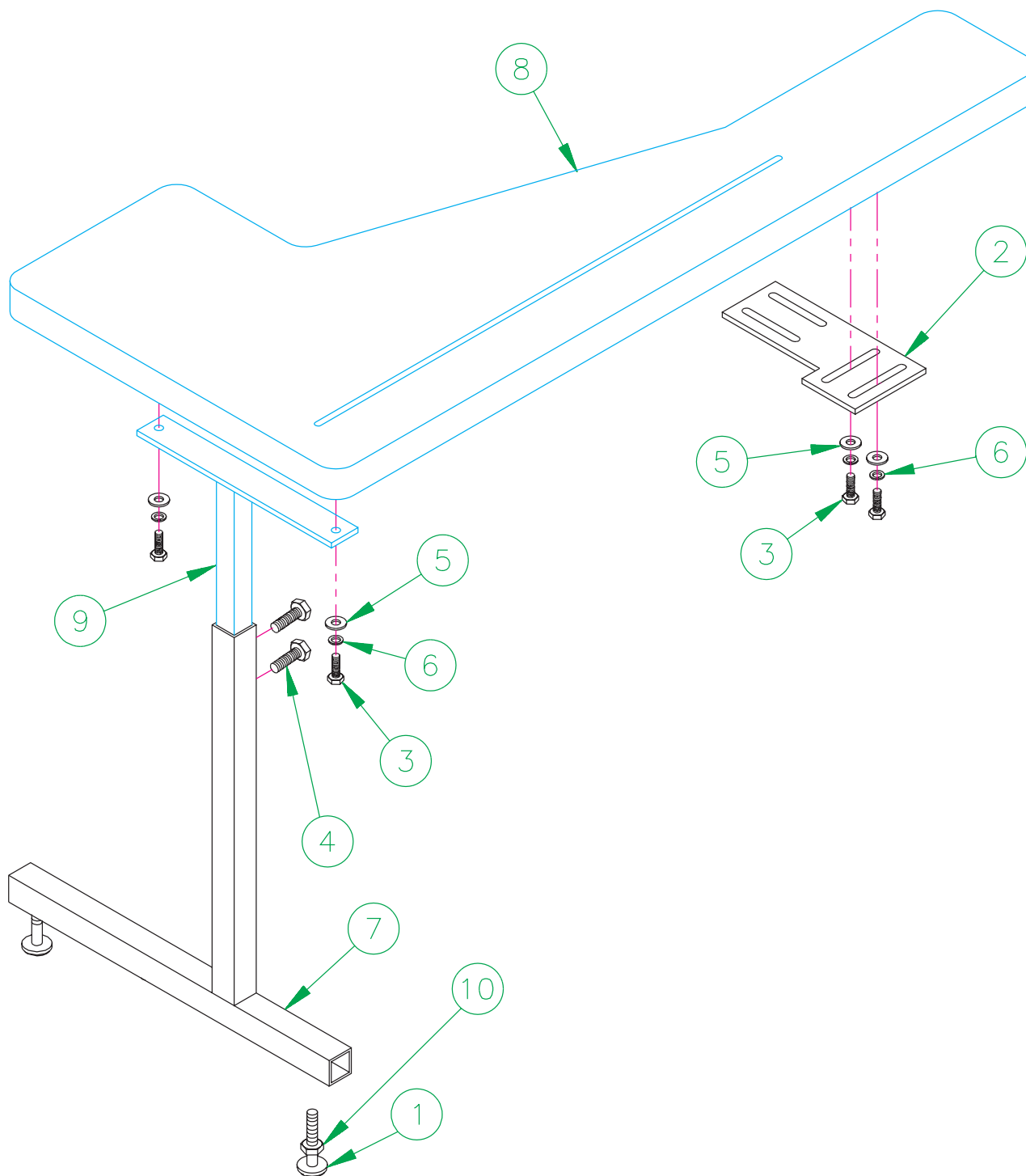




## 11745B Bundle Table

See Pg. 9

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAQSU-4-4	Quick St Union	1	11	WWFS5/16	5/16 Flat Washer	4
2	24143	Table Mount	1	12	WWL5/16	Lock Washer	4
3	NNH5/8-11	Hex Nut	2	13	24142	Mount for Weldment	1
4	MM6103K33	Foot Leveler	1	14	1745-12A	Table Top	1
5	NNK1/4-20	Kep Nut	4	15	1745-3	Base Ext Assy	1
6	SSHC01096	Scr,Hx Cp 1/4-20x1 1/2	4	16	1745-4	Bundle Table Base	1
7	SSHC10048	Scr,Hx cp 5/16-18x3/4	4	17	24145	Supp Adj Table	1
8	TTH32429	Threaded Handle	1	18	24037	Leg Rod	1
9	TTH32430	Threaded Handle	2	19	24118	Brkt Adj Mount	1
10	WWFS1/4	1/4 Flat Washer	4	AAC Drawing Number = 191070C Rev. 4			

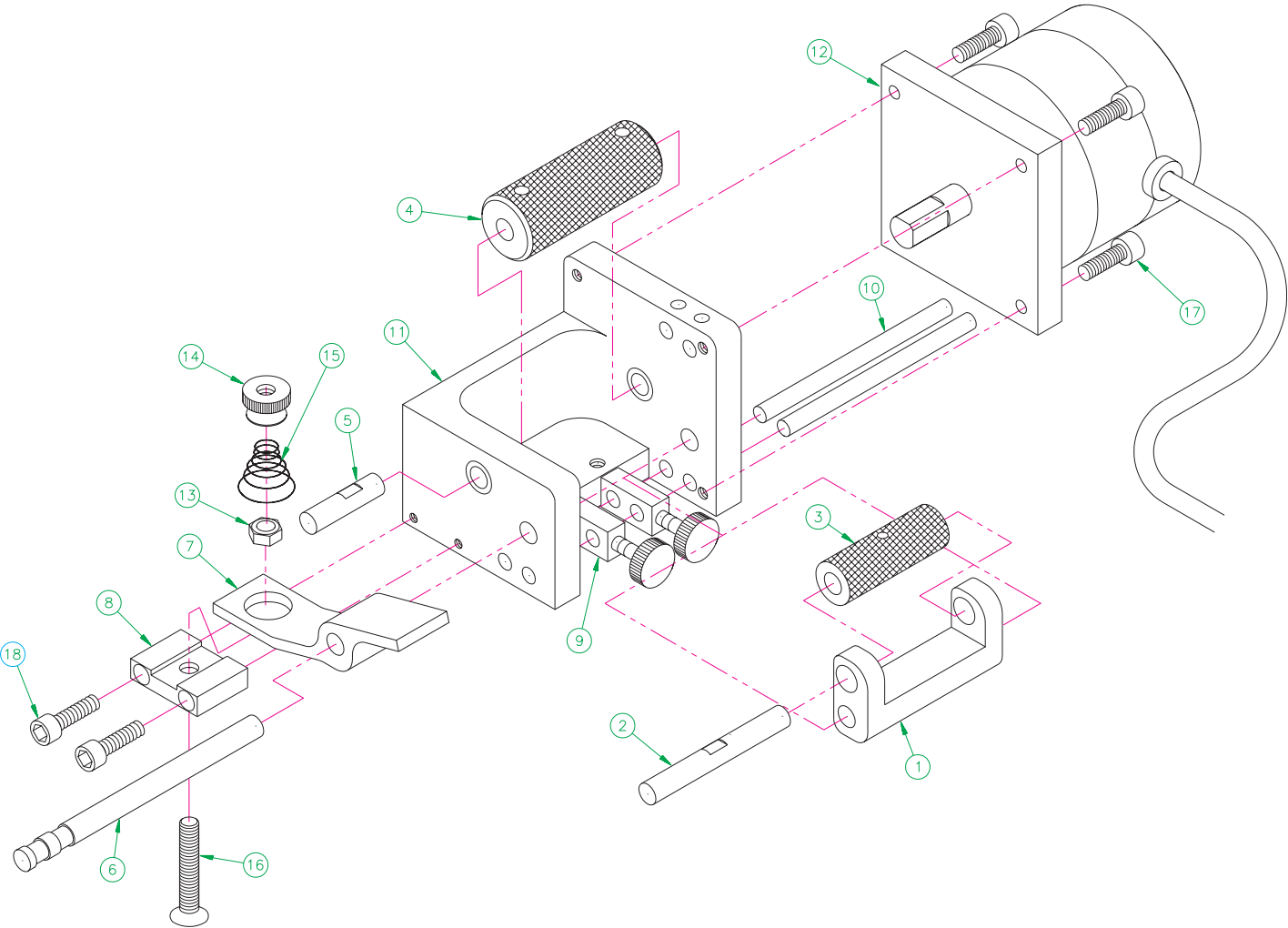


## 11745D Bundle Table

See Pg. 11

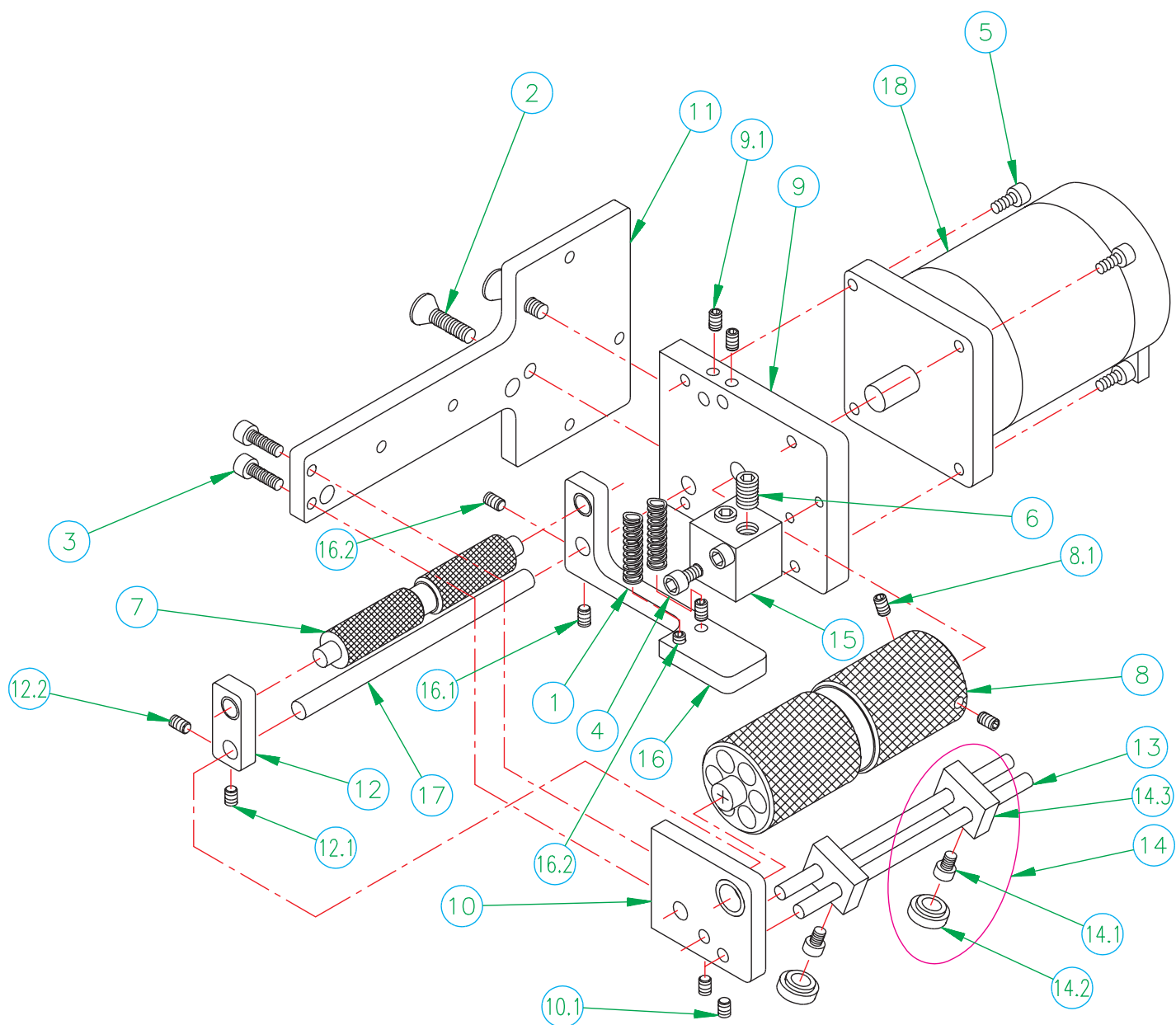
Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	MMFB4444	Rubber Feet	2	6	WWL5/16	Washer, Lock	4
2	1745-9	Bracket, Table	1	7	1745-10	Base	1
3	SSHC10064	Scr,Hx Cp 5/16-18x1	4	8	1745-12A	Table Top	1
4	SSHC25048	Scr,Hx Cp 3/8-16x3/4	2	9	23430	Table Support	1
5	WWF5/16	Washer, Flat	4	10	NNH5/16-18	Hex Nut 5/16-18	2

AAC Drawing Number = 190074A Rev. 4



## 28M-100 Minature Electronic Metering Device

				See Pg. 9			
Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	28M001	Yoke Small Roller	1	10	28M010	Straight Rod	2
2	28M002	Rod Straight	1	11	28M011	Main Yoke	1
3	28M003	Pressure Roller	1	12	AP-22E-104	Step Motor	1
4	28M004	Drive Roller	1	13	NNH10-32	10-32 Nut	1
5	28M005	Drive Roller Axle	1	14	NNT032	Thumb Nut	1
6	28M006	Pivot Axle	1	15	RRBEEHIVES	Spring	1
7	28M007	Release Lever	1	16	SSFC98080	Scr,Fl Al 10-32x1 1/4	1
8	28M008	Spring Post Mount	1	17	SSSC90032	Scr,So Cp 8-32x1/2	4
9	28M009	Guide Block	2	18	SSSC80056	Scr,So Cp 6-32x7/8	2
				AAC Drawing Number - 191105C Rev. 2			



## NOTES:

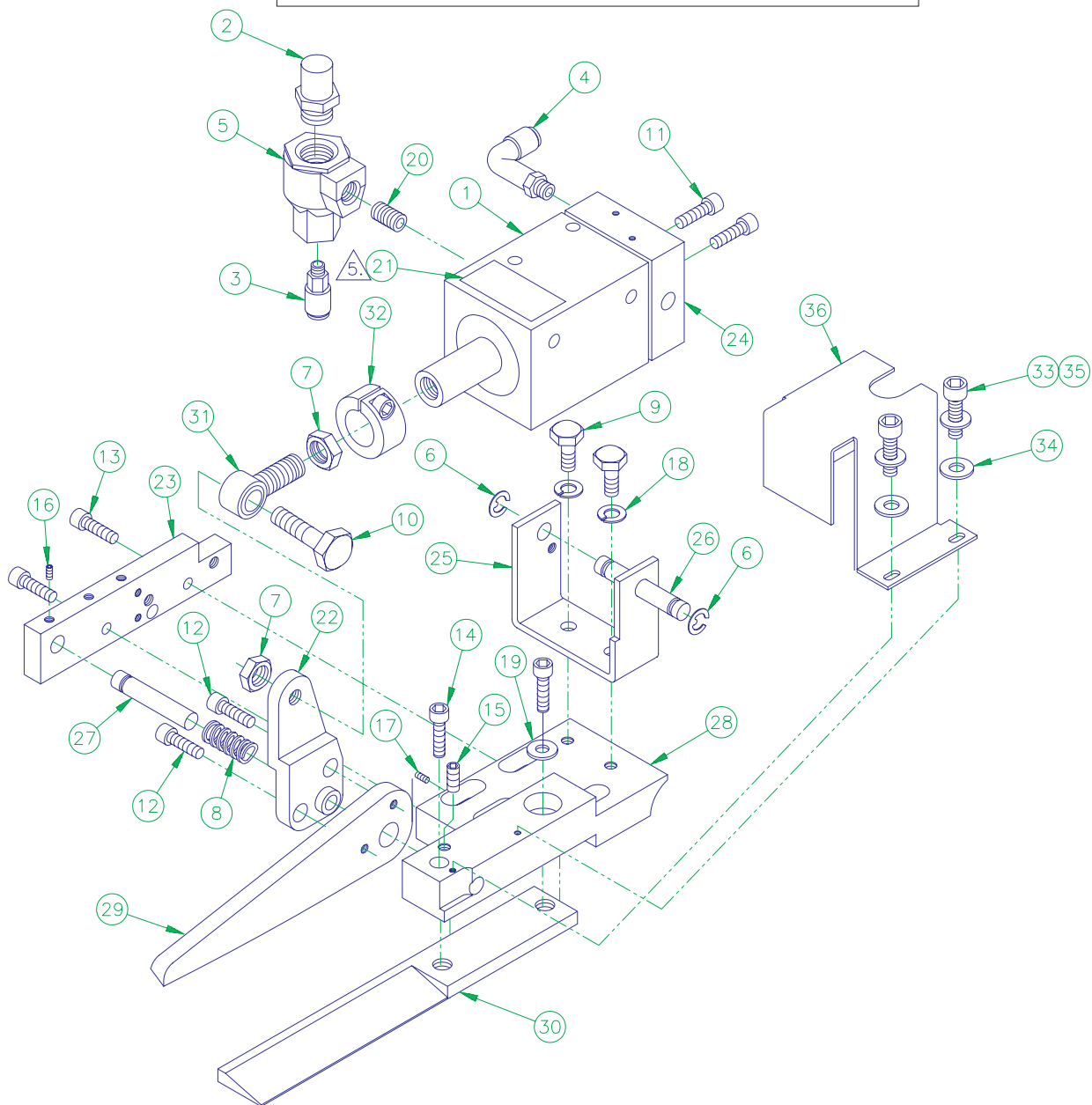
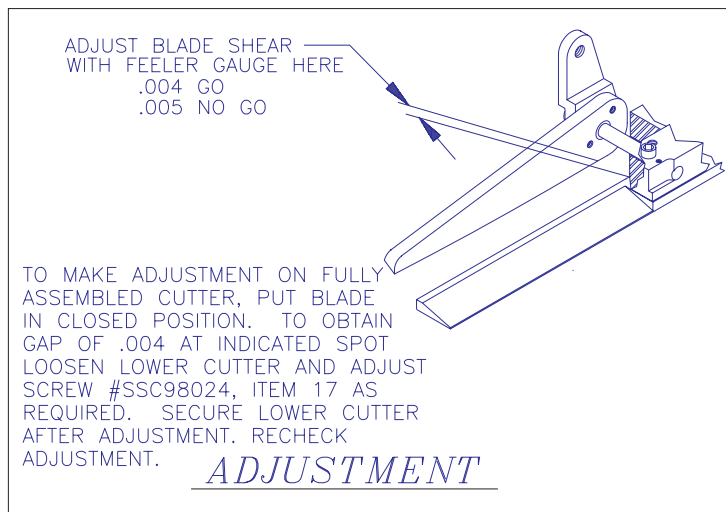
1. THIS ASSEMBLY IS BROKEN DOWN INTO SUB-ASSEMBLIES WHOSE PARTS USE DECIMAL NUMBERS. ALL DECIMAL NO.'S COME WITH THE PARENT NO. OF THE PART. EXAMPLE IS PART OF THE SUB-ASSEMBLY.



**350-5600A Elastic Metering Device**

See Pg. 11

<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>	<b>Pg.</b>	<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>	<b>Pg.</b>
1	RRLC029C10	Spring, .24 OD, 1.0 L	2	12.1	SSSS98008	Scr, Soc Set 10-32 X 1/8	1
2	SSFC98032	Scr,Flt Aln,10-32X1/2	2	12.2	SSSS98012	Scr,Soc Set 10-32X3/16	1
3	SSSC90032	Scr,Soc Cap,8-32X1/2	2	13	28109	Rod, Straight, 1018	2
4	SSSC90064	Scr,Soc Cap,8-32X1	2	14	28110	Tape Guide	2
5	SSSC98032	Scr,Soc Cap 10-32X1/2	4	14.1	SSSC90016Z	Scr,Soc Cap 8-32X1/4	2
6	SSSS20016	Scr, Soc Set 5/16-24X1/4	2	14.2	SST#8	Thumb Screw Knob, #8	2
7	28102D	Roller Pressure	1	14.3	28110A	Guide Block	2
8	28103D	Roller, Drive	1	15	28112A	Roller Support	1
8.1	SSSS98016	Scr, Soc Set 10-32 X 1/4	2	15.1	SSSS20016	Scr, Soc Set 5/16 X 1/4	2
9	28104A	Mount, Step Motor	1	16	28113A	Lever, Pivot Arm	1
9.1	SSSS98012	Scr,Soc Set 10-32X3/16	2	16.1	SSSS98012	Scr,Soc Set 10-32X3/16	1
10	28105A	Outboard Support	1	16.2	SSSS98024	Scr,Soc Set 10-32X3/8	3
10.1	SSSS98012	Scr, Soc Set,10-32X3/16	2	16.3	UUAA347-02	Bearing Bronze	1
11	28106	Base	1	17	28124	Rod, Straight, 1018	1
12	28107A	Arm, Pivot, Dual Spring	1	18	AP-22E-102	Step Motor, Modified	1
				AAC Drawing Number = 191501C Rev. 0			



**AAT404 4" Cutter**

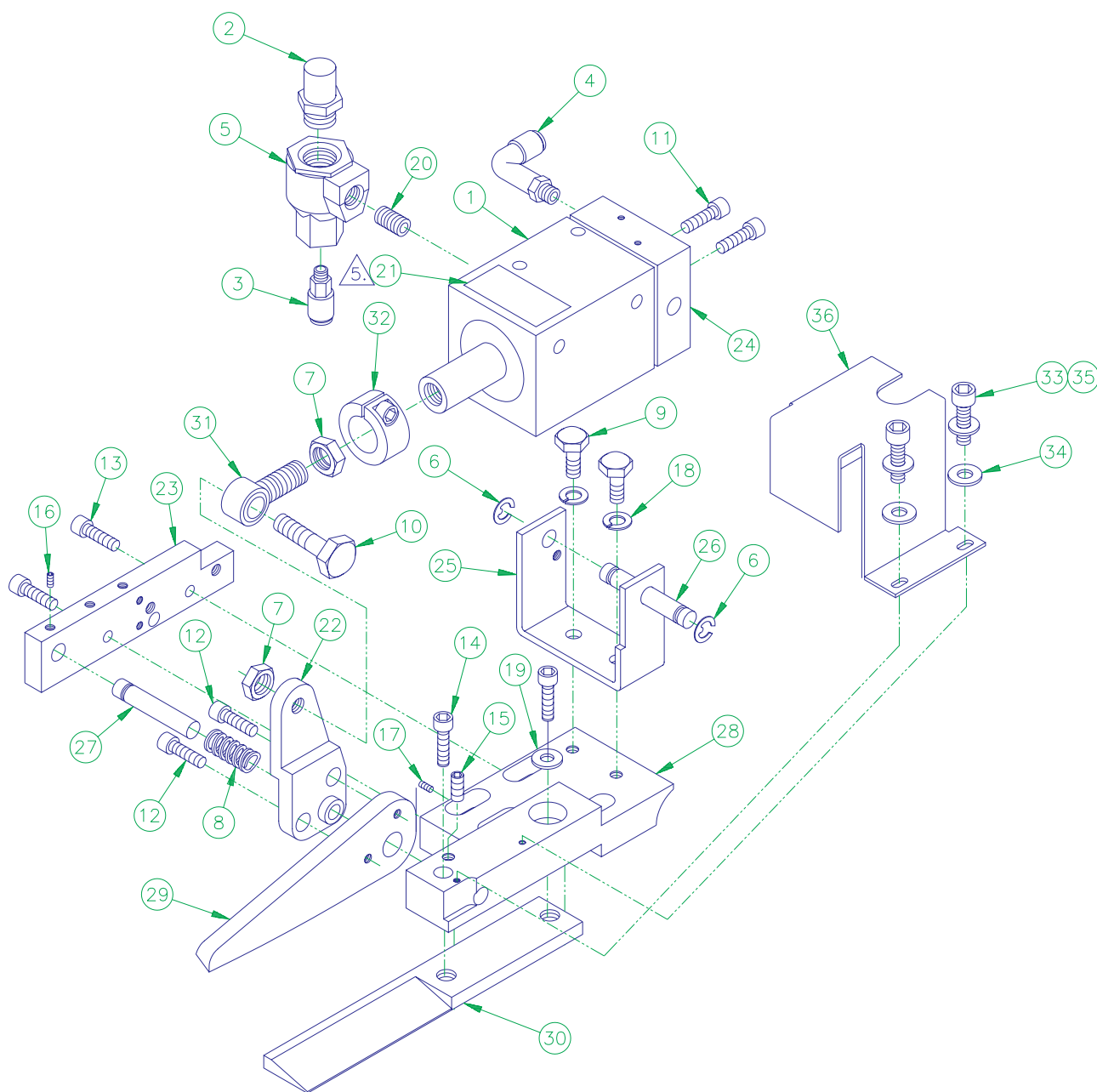
See Pg. 9

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AACSHH104	Air Cylinder	1	19	WWFS10	Washer, Flat, 10 SAE	1
2	AAFP28	Muffler	1	20	273-4-504	Close Nipple	1
3	AAQMC-4-8	Male Connector	1	21	AT-LAB#L-1	Label, Caution	2
4	AAQME-4-8	Male Elbow	1	22	AT301-10	Drive Lever	1
5	AAVSQE1	Exhaust Valve	1	23	AT301-11	Support	1
6	MM8407A132	5/16" E Ring	2	24	AT301-13	Cylinder Adaptor	1
7	NNJ5/16-24	5/16-24 Jam Nut	2	25	AT301-44	Cylinder Yoke	1
8	RRLC072HJ6	Spring	1	26	AT301-15	Cylinder Shaft	1
9	SSHC01048	Scr,Hx Cp 1/4-20x3/4	2	27	AT301-17	Cutter Shaft	1
10	SSHC20056	Scr,Hx Cp 5/16-24x7/8	1	28	AT301-43	Main Block	1
11	SSSC01048	Scr,So Cp 1/4-20x3/4	2	29	AT401-03	4" Cutter, Upper	1
12	SSSC98024	Scr,So Cp 10-32x3/8	2	30	AT401-01	4" Cutter, Lower	1
13	SSSC98032	Scr,So Cp 10-32x1/2	2	31	AT604-03	Rod End	1
14	SSSC98048	Scr,So Cp 10-32x3/4	2	32	CCCL10F	Clamp Collar	1
15	SSSS01016	Scr,So St 1/4-20x1/4	1	33	SSSC80032	Scr,So Cp 6-32x1/2	2
16	SSSS98016	Scr,So St 10-32x1/4	1	34	WWFS6	Washer	2
17	SSSS98024	Scr,So St 10-32x3/8	1	35	WWL6	Washer, Lock	2
18	WWL1/4	1/4 Lock Washer	2	36	AT301-53	Guard	1
AAC Drawing Number - 191206C Rev. 0							

ADJUST BLADE SHEAR  
WITH FEELER GAUGE HERE  
.004 GO  
.005 NO GO

TO MAKE ADJUSTMENT ON FULLY  
ASSEMBLED KNIFE, PUT BLADE  
IN CLOSED POSITION. TO OBTAIN  
GAP OF .004 AT INDICATED SPOT  
LOOSEN LOWER KNIFE AND ADJUST  
SCREW #SSC98024, ITEM 17 AS  
REQUIRED. SECURE LOWER KNIFE  
AFTER ADJUSTMENT. RECHECK  
ADJUSTMENT.

### ADJUSTMENT



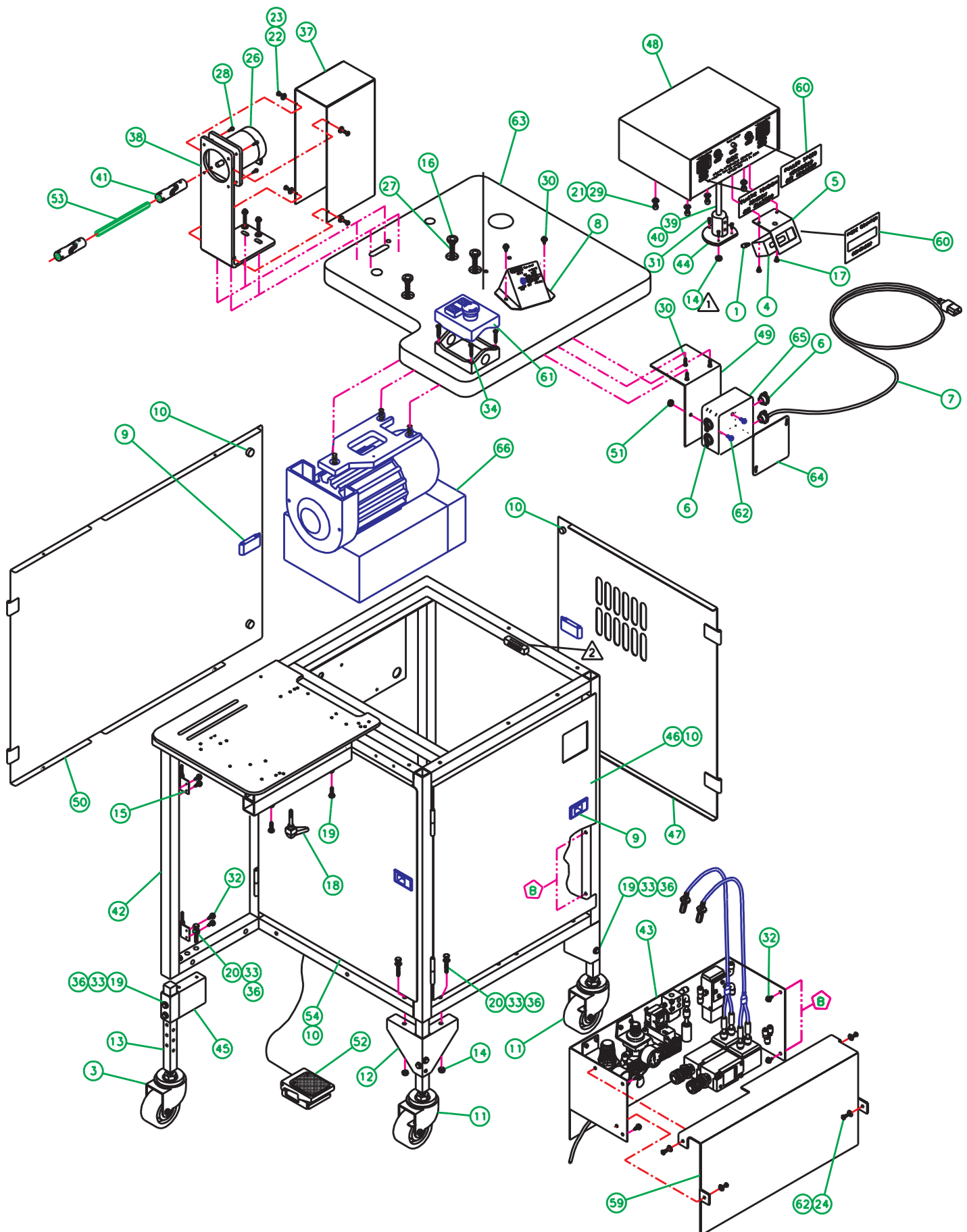
**AAT304 3" Cutter**

See Pg. 11

<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>	<b>Pg.</b>	<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>	<b>Pg.</b>
1	AACSHH104	Air Cylinder	1	19	WWFS10	Washer, Flat, 10 SAE	1
2	AAFP28	Muffler	1	20	273-4-504	Close Nipple	1
3	AAQMC-4-8	Male Connector	1	21	AT-LABEL-1	Label, Caution	2
4	AAQME-4-8	Male Elbow	1	22	AT301-10	Driver Lever	1
5	AAVSQE1	Exhaust Valve	1	23	AT301-11	Support	1
6	MM8407A132	5/6" E Ring	2	24	AT301-13	Cylinder Adaptor	1
7	NNJ5/16-24	5/16-24 Jam Nut	2	25	AT301-44	Cylinder Yoke	1
8	RRLC072HJ6	Spring	1	26	AT301-15	Cylinder Shaft	1
9	SSHC01048	Scr,Hx Cp 1/4-20x3/4	2	27	AT301-17	Cutter Shaft	1
10	SSHC20056	Scr,Hx Cp 5/16-24x7/8	1	28	AT301-43	Main Block	1
11	SSSC01048	Scr,So Cp 1/4-20x3/4	2	29	AT301-09	3" Cutter, Upper	1
12	SSSC98024	Scr,So Cp 10-32x3/8	2	30	AT301-08	3" Cutter, Lower	1
13	SSSC98032	Scr,So Cp 10-32x1/2	2	31	AT604-03	Rod End, Modified	1
14	SSSC98048	Scr,So Cp 10-32x3/4	2	32	CCCL10F	Clamp Collar	1
15	SSSS01016	Scr,So St 1/4-20x1/4	1	33	SSSC80032	Scr,Sp Cp 6-32x1/2	2
16	SSSS98016	Scr,So St 10-32x1/4	1	34	WWFS6	Washer	2
17	SSSS98024	Scr,So St 10-32x3/8	1	35	WWL6	Washer, Lock	2
18	WWL1/4	Washer, Lock, 1/4	2	36	AT301-53	Guard	1

AAC Drawing Number = 191008C Rev. 8



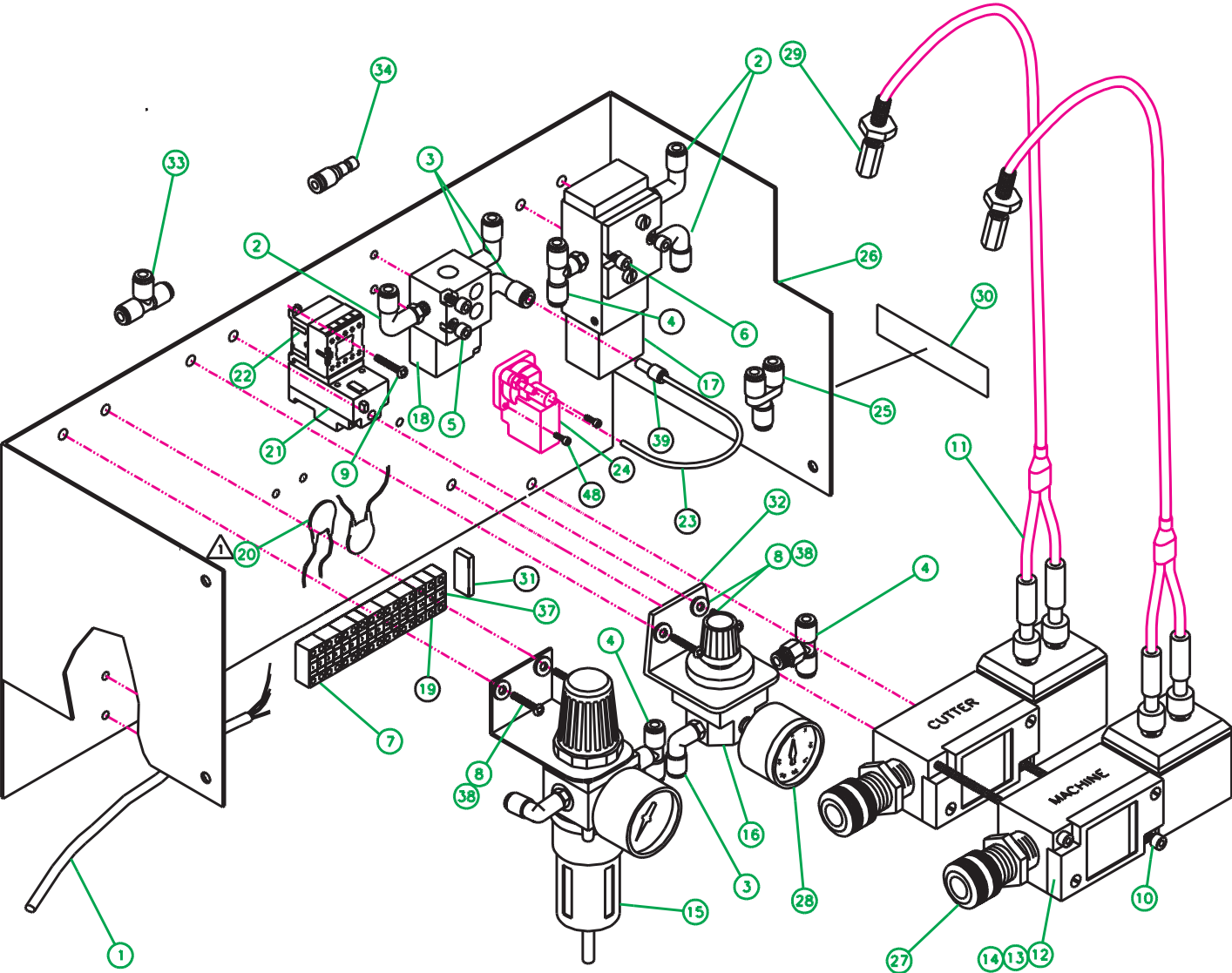


# 1536-100 Power Console Assembly

See Pg. 11

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAQMC-5-10	Quick Male Conn	1	34	SSZP#6048	Scr,Pn Sh Mtl#6 x 3/4	4
2	EEFE-RR2	Reflective Tape	3'	35	W1061-3	Nut Wire	3 Δ2
3	MMTP113LPS	3" Rubber Swivel	2	36	WWL1/4	1/4 Lock Washer	16
4	AAPZAEORC	Pneumatic Adding Counter	1	37	23690A	Motor Cover	1
5	1535-297	Counter Mount Bracket	1	38	23687A	Bracket Step Motor	1
6	K-235	Romax Connector	4	39	011-055B	Mtg Brkt Control Box	1
7	EE37F3311	Cee Power Cord	1	40	011-116	Stand, Control Box	1
8	1536-055	Push Button Box	1	41	3524-06A	"U" Joint Mod	2
9	MM40450010	Slide Lock Fastener	4	42	23069	Power Console Stand	1
10	MMSLD-ECH	Rubber Bumper	8	43	1536CP	Control Panel	1 27
11	MM503022LB	Caster Locking	2	44	AP-1721	Stand Base Complete	1
12	26128	Leg Mount	3	45	23074A	Leg Extension	1
13	26127	Leg	4	46	23082-A	Front Door	1
14	NNK1/4-20	1/4-20 Kep Nut	7	47	23083	Right Side Door	1
15	MM1155RA	Hinge Male	2	48	AP-28-800B	Control Box 2 Channel	1
16	NNM103	Recessed Nut, 5/16-18	3	49	1278-6688	Electrical Box Mount	1
17	SSPS80032	Scr,Pn Sl 6-32x1/2	2	50	23082-B	Rear Door Assembly	1
18	TTH32415	Threaded Handle	1	51	NNK10-32	10-32 Kep Nut	2
19	SSHC01048	Scr,Hx Cp 1/4-20x3/4	10	52	1536-069	Footswitch, Assembly	1
20	SSHC01096	Scr,Hx Cp 1/4-20x1 1/2	8	53	3524-6640	Shaft	1
21	WWSI8	No. 8 Int Tooth Washer	4	54	23151A	Left Side Door	1
22	SSPS80016	Scr,Pn Hd Sl 6-32x1/4	4	55	28128	Grounding Strap	1
23	WWSI6	Internal Tooth Washer	4	56	1536APD	Pneumatic Diagram	1 30
24	SSPS90032	Scr,Pn Hd Sl 8-32x1/2	4	57	1536AWD	Wiring Diagram	1 31
25	3524-06I	Installation Dwg	1	58	1536AWD1	Wiring Diagram	1 32
26	011-020	Stepping Motor	1	59	1536-065	Control Panel Cover	1
27	K-102-21	Rod, Threaded	3	60	1536CBLAB1	Label, Counters	2
28	SSSC98032	Scr,So Cp 10-32x1/2	4	61	EED-014	Switch, ON/OFF, EM Stop	1
29	SSSC90032	Scr,So Cp 8-32x1/2	4	62	SSPS98024	Scr,Pn Hd Ph 10-32x3/8	2
30	SSZH#10064	Scr,Hx Sh Me No.10x1	5	63	23630	AP-23 Table Top	1
31	SSFC01160	Scr,Fl Cp 1/4-20x2 1/2	3	64	WWF8	No. 8 Washer	4
32	SSZS93032	Scr,Sh Me 10-16x1/2sd	8	65	K-233	Square Box, Electrical	1
33	WWF1/4	1/4 Washer	16	66	K-234	Cover, 4" Square	1

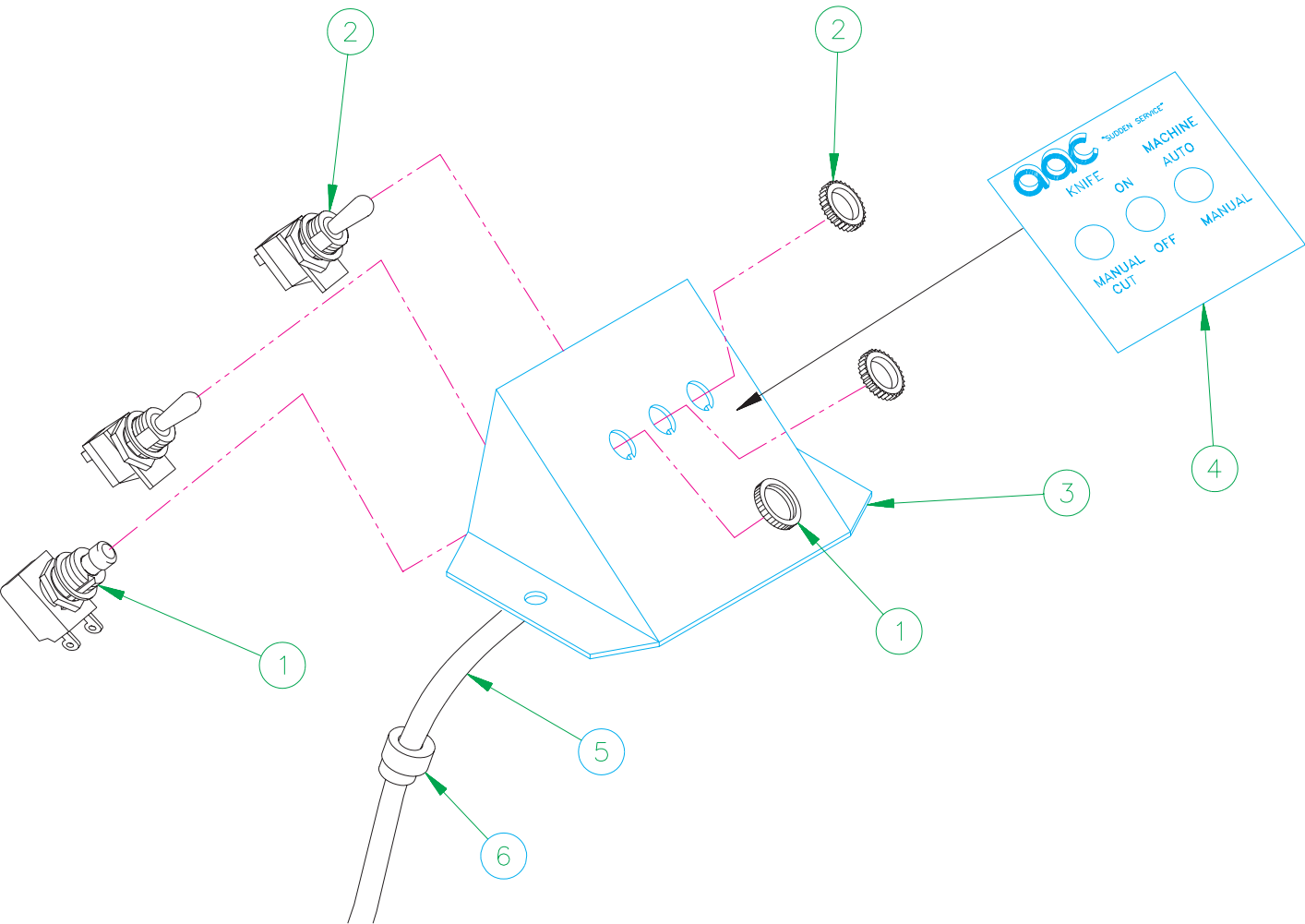
AAC Drawing Number = 191063C Rev. 16



# 1536CP Control Panel

See Pg. 25

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	EE18-3	Rubber Coated Wire	7'	25	AAQUY-5-5	Quick Union Y	1
2	AAQME-4-8	Quick Male Elbow	3	26	1536-054	Control Panel	1
3	AAQME-5-8	Quick Male Elbow	3	27	EECE1	Cable Entry	2
4	AAQBT-4-8	Quick Branch T	3	28	AA198-503	0-30PSI Gauge	1
5	SSSC80064	Scr, So Cp 6-32x1	2	29	1535-340	Electric Eye Guard	2
6	SSSC98112H	Scr,So Cp 10-32x1 3/4	2	30	1536CBLAB2	Label	1
7	FF264-341	Dual Wago Terminal	6	31	FF264-371	Wago End Cap	1
8	SSPPT98032	Scr,Pn Ph 10-32x1/2	4	32	4130-001	Bracket	1
9	SSPPT90048	Scr,Pn Ph 8-32x3/4	2	33	AAQUT-4-4	Quick Union T	2
10	SSSC98224	Scr,So Cp 10-32x3 1/2	2	34	AAQPR-5-4	Quick Plug Red	2
11	EEFE-B2B-7	Photo-Elec Fiber Opt	2	35	FF59F1802	2Pin Male Conn.	2 Δ1
12	EEMPF6	Photo-Elec Control Hd	2	36	FF31F1022	.093 mMale Pin	4 Δ1
13	EEMPV14	Relay Base	2	37	1904-1114	Home Pos. Cable	1
14	EEMPA188	Photo-Elec Logic	2	38	WWFS10	Washer	4
15	AA198-5	Air Regulator	1	39	AAQPR-8-5	Quick Plug Reducer	1
16	AA198-502	Air Regulator	1	40	1536AWD1	Wiring Diagram	1 32
17	AAE711C240	Valve, Air Solenoid	1	41	1536AWD	Wiring Diagram	1 31
18	AAE45A240A	Valve, Air Solenoid	1	42	1536APD	Pneumatic Diagram	1 30
19	FF364-311	Single Wago Terminal	6	43	AAF3/16	Plastic Clamp	4 Δ2
20	FF250LA40A	Varistor	2	44	AAF1/4	Plastic Clamp	4 Δ2
21	EECT460	Thermal Relay	1	45	SSPP80032	Scr,Pn Ph 8-32x1/2	4 Δ2
22	EECA491024	Mini Contractor	1	46	WWFS6	SAE FTRlat Washer	4 Δ2
23	AATP4-3	Black Urethane Tube	.2ft	47	EE18-4	Rubber Coated Wire	6ft
24	AAVF51FM1B	Air Electric Switch	1	AAC Drawing Number = 191043C Rev. 9			



1536-055 Push Buttom Box

See Pg. 25

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	FF23F118	Push Button Switch	1	4	1536LAB1	Label	1
2	FF23F385	Toggle Switch	2	5	FF36FF1017W	Motor Cable	3'
3	1536-053	Push Button Box	1	6	W17	Power Cord Clamp	1
AAC Drawing Number = 150040B Rev. 1							

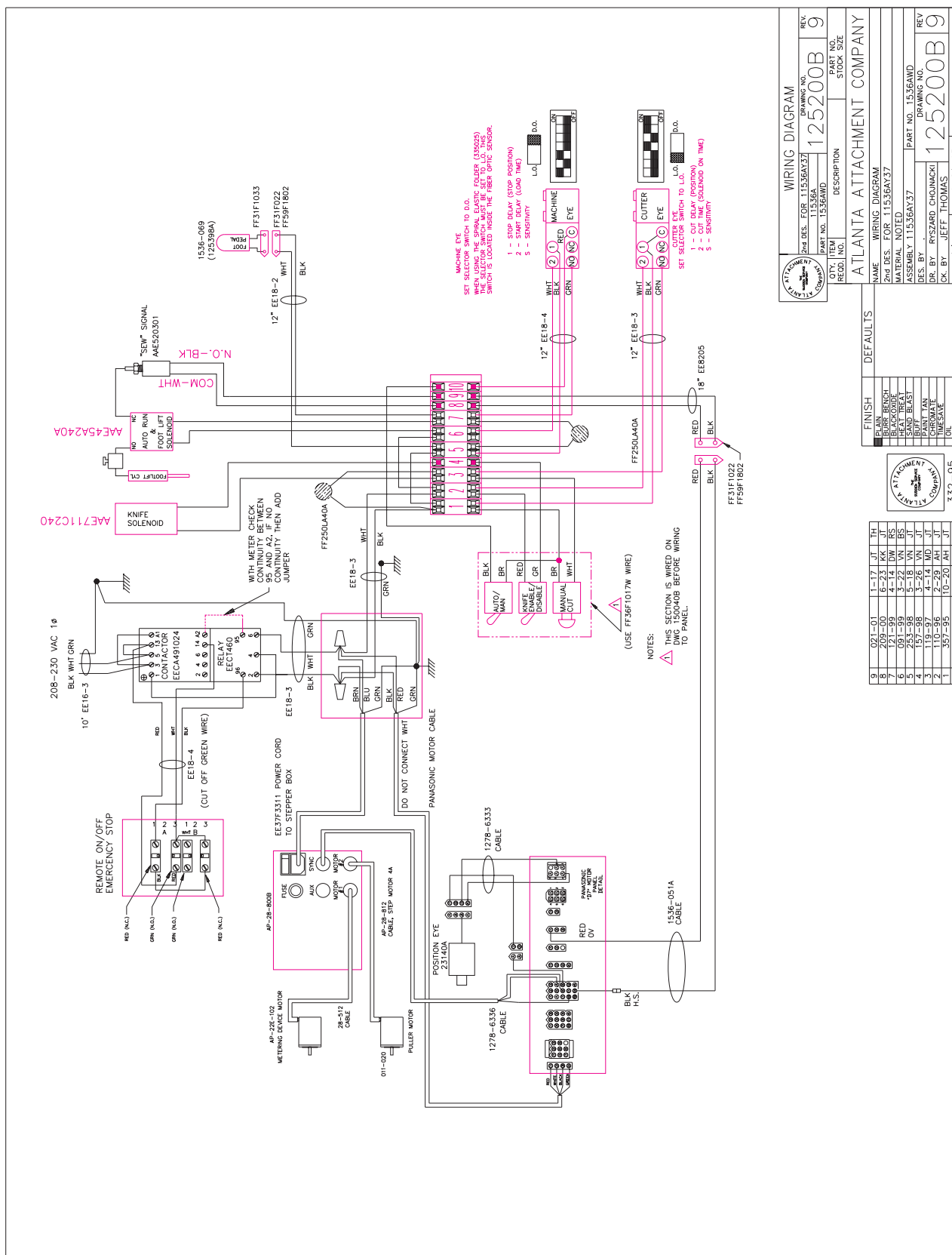


## **Pneumatic and Wiring Diagrams**

**See Pgs. 9 and 11**

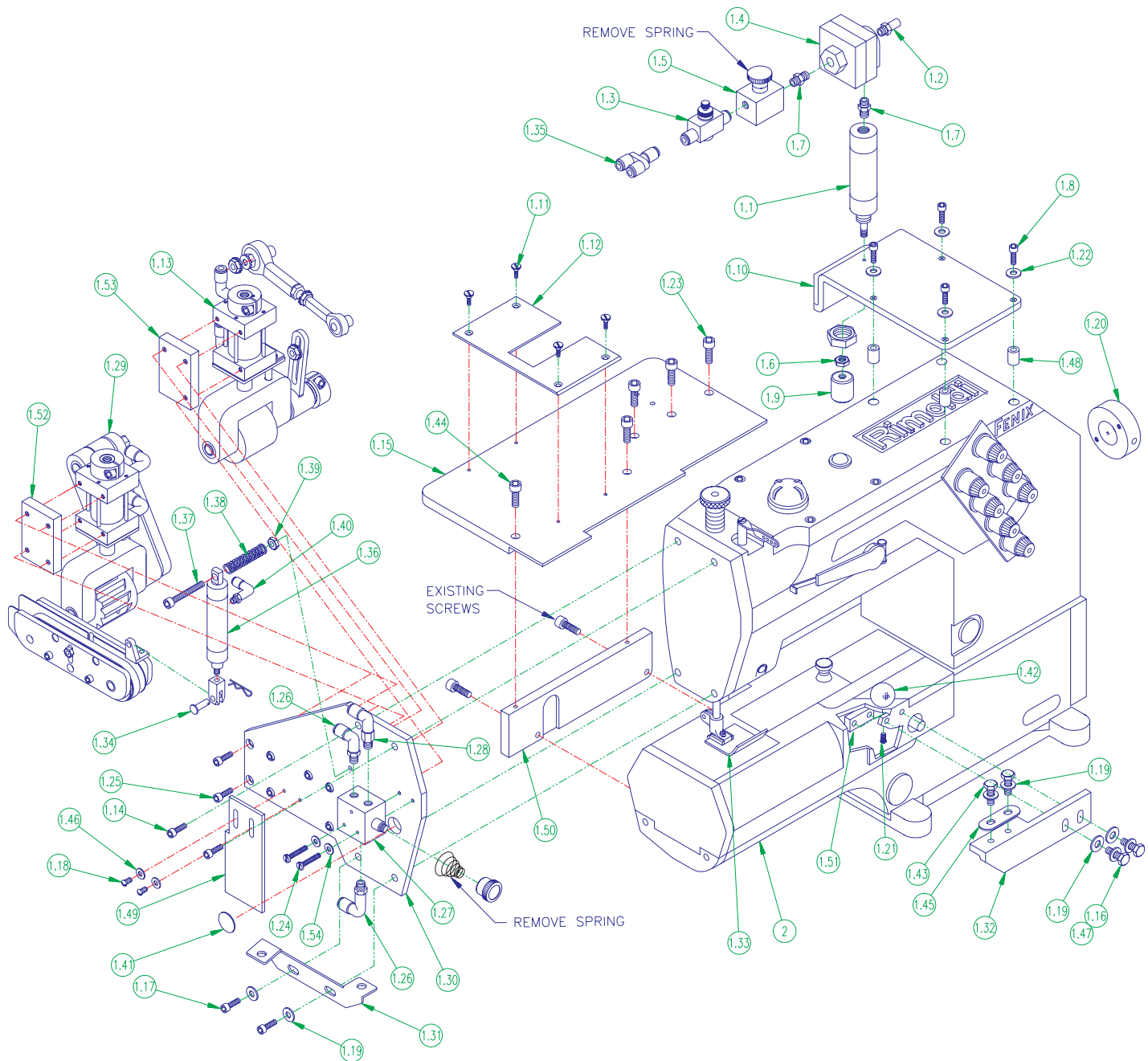


**See Pgs. 9 and 11**





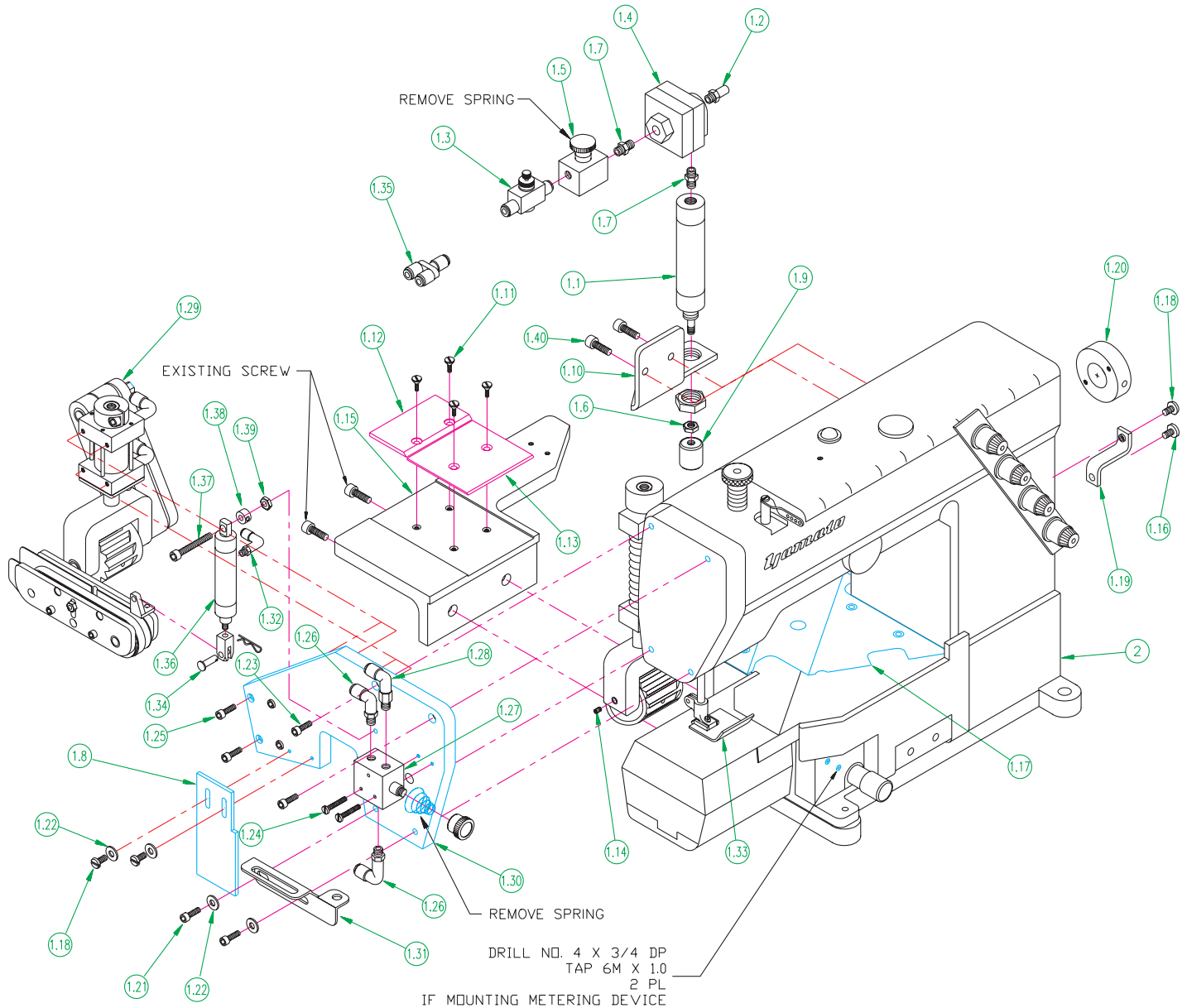
**Sewing Head Details  
For  
11536A**



# 1535PA-R62 Sewing Head Assembly

See Pg. 9

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	1535PAR62S	Sewing Head Parts	1	1.28	AAQMEL-5-8	Quick Male Elbow	1
1.1	AAC6S-1-H	Air Cyl, Sa, AAC	1	1.29	1536-056	Puller Conveyor	1 39
1.2	AAFP18	Muffler	1	1.30	1536-057	Front Mount	1
1.3	AA2000F-03	Flow Control	1	1.31	1536-064	Eye Mount Bracket	1
1.4	AAVNAQ2000	Quick Exhaust Valve	1	1.32	1536-062	Folder Mount	1
1.5	AAVMB32	Switch	1	1.33	M1-1535E	Foot	1
1.6	NNJ5/16-24	Jam Nut	1	1.34	AAFCT-8	Humphery Clevis	1
1.7	AAF122A-A	Hex Close Nipple	2	1.35	AAQUY-5-5	Quick Union Y	1
1.8	SSSCM5X40M	Scr,So Cp M5x1x40mm	4	1.36	1535-377	Air Cylinder	1
1.9	11200A	Bumper	1	1.37	SSSC98080	Scr,So Cp 10-32x1 1/4	1
1.10	112021	Bracket	1	1.38	RRLC024C10	Spring	1
1.11	SSFS80012	Scr,Fl Sl 6-32x3/16	4	1.39	NNK10-32	10-32 Kep Nut	1
1.12	1536-061	Skid Plate	1	1.40	AAQME-5-10	Quick Male Elbow	1
1.13	1536-066	Front Puller	1 40	1.41	MM3071	Heyco Plug	1
1.14	SSSC6MX16M	Scr,So Cp M6x1x16mm	2	1.42	SSMBK13	Plastic Knob	1
1.15	1536-059	Mounting Plate	1	1.43	SSHC01040	Scr,Hx Cp 1/4-20x5/8	2
1.16	SSHC01048	Scr,Hx Cp 1/4x20x3/4	2	1.44	SSSC90040	Scr,So Cp 8-32x5/8	2
1.17	SSSC6MX20M	Scr,So Cp M6x1x20mm	2	1.45	WW25DW	Washer Plate	1
1.18	SSTS85024	Scr,Tr Sl 6-40x3/8	2	1.46	WWB5/32	5/32 Brass Washer	2
1.19	WWFS1/4	1/4 Washer	6	1.47	WWL1/4	Lock Washer	2
1.20	1278-6364	Tape Mounting	1	1.48	1535-231	Spacer	4
1.21	SSBC01032	Scr,But Cp 1/4-20x1/2	1	1.49	1536-058	Cutter Guard	1
1.22	WWFS10	No. 10 Washer	4	1.50	1536-060	Cutter Mounting Plate	1
1.23	SSSC4MX20M	Scr,So Cp M4x.07x20mm	3	1.51	1536-063	Nut Plate	1
1.24	SSPS90080	Scr,Pn Sl 8-32x1 1/4	2	1.52	350288	Spacer Pull Cyl	1
1.25	SSSC90048	Scr,So Cp 8-32x3/4	7	1.53	350288A	Spacer Pull Cyl	1
1.26	AAQME-5-8	Quick Male Elbow	2	1.54	WWSI6	Washer	2
1.27	AAVMB43	Valve	1	2	SRIMF71112	Sewing Head	1
				AAC Drawing Number - 191208C Rev. 0			

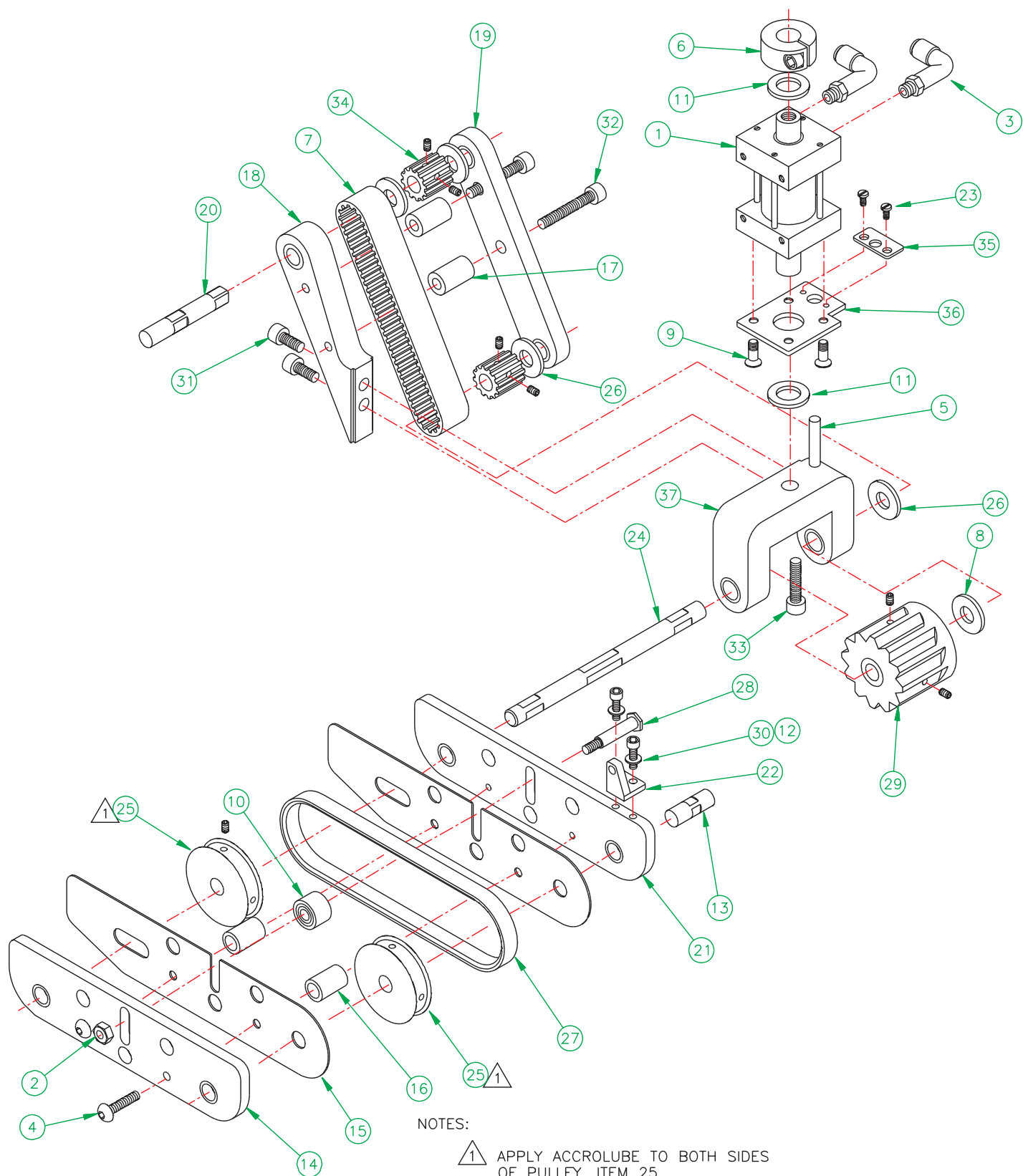




**1535PA-Y37 Sewing Head Assembly**

See Pg. 11

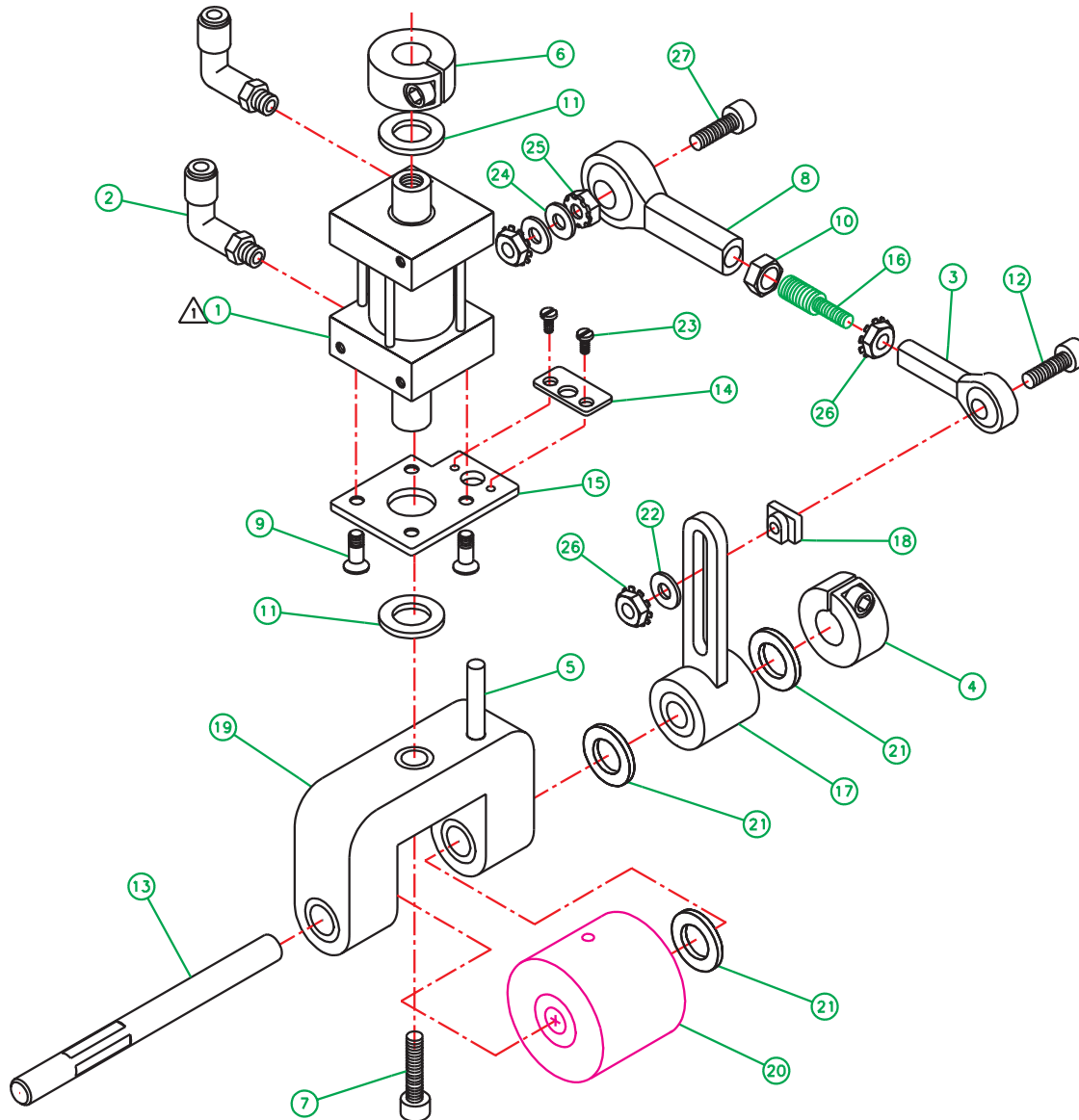
Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	1535PAY37S	Sewing Head Parts	1	1.21	SSPS4MX25	Scr,Pn Sl M4x.7x25mm	2
1.1	AAC6S-1-H	Air Cyl Sa, AAC	1	1.22	WWFS10	No. 10 Washer	4
1.2	AAFP18	Muffler	1	1.23	SSPSM4X20M	Scr,Pn Sl M4x.07x20mm	2
1.3	AA2000F-03	Flow Control	1	1.24	SSPS80080	Scr,Pn Sl 6-32x1 1/4	2
1.4	AAVNAQ2000	Quick Exhaust Valve	1	1.25	SSSC85032	Scr,So Cp 8-32x1/2	4
1.5	AAVMB32	Switch	1	1.26	AAQME-5-8	Quick Male Elbow	2
1.6	NNJ5/16-24	Jam Nut	1	1.27	AAVMB43	Valve	1
1.7	AAF122A-A	Hex Close Nipple	2	1.28	AAQMEL-5-8	Quick Male Elbow	1
1.8	1536-058	Cutter Guard	1	1.29	1536-056	Puller Conveyor	1 39
1.9	11200A	Bumper	1	1.30	1536-040A	Face Plate	1
1.10	112013	Bracket	1	1.31	1536-041	Eye Mount Bracket	1
1.11	SSFS90016	Scr,Fl Sl 8-32x1/4	4	1.32	AAQME-5-10	Quick Male Elbow	1
1.12	1536-049	Rear Skid Pl	1	1.33	M1-1535E	Foot Mod	1
1.13	1536-048	Front Skid Pl	1	1.34	AAFCT-8	Humphrey Cleavis	1
1.14	SSSM5X5	Scr, Sl Set M5x.8x5m	1	1.35	AAQUY-5-5	Quick Union Y	1
1.15	1536-039A	Skid Pl Mount	1	1.36	1536-377	Air Cylinder	1
1.16	SSCM6X10	Scr, Ch Hd 10-32x2 1/4	1	1.37	SSSC98144	Scr,So Cp 10-32x2 1/4	1
1.17	1536-050	Cover Plate Mod	1	1.38	RRCL024C14	Spring	1
1.18	SSPS98024	Scr,Pn Sl 10-32x3/8	3	1.39	NNK10-32	10-32 Kep Nut	1
1.19	1536-052	Bracket Belt Guard	1	1.40	SSSC6MX16M	Scr,So Cp M6x1x16mm	2
1.20	1278-6364	Tape Mounting	1	2	SYAM-2640P	Sewing Head	1
				AAC Drawing Number = 191045C Rev. 4			



**1536-056 Pulley Conveyor**

See Pgs. 35 and 37

<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>	<b>Pg.</b>	<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>	<b>Pg.</b>
1	AACFSD091	Air Cylinder	1	20	1535-253	Shaft, Flatted	1
2	NNE1/4-20	Nut Elas, 1/4-20	1	21	1535-294	Conv Right Side	1
3	AAQME-5-8	Quick Male Elbow	2	22	1535-338	Mount Lift	1
4	SSBC95072	Scr,But Cp 10-24x1 1/8	2	23	SSTS85012	Scr,Tr Sl 6-40x3/16	2
5	IID016X128	Dowel Pin	1	24	1535-366	Puller Shaft	1
6	CCCL8F	Clamp Collar	1	25	1535-373	Drive Pulley, Conv	2
7	GG110XL75U	Gear Belt	1	26	3517	Thrust Washer	4
8	BBTT710-01	Bearing	1	27	1535-378	Conv Drive Belt	1
9	SSFS90016	Scr,Fl Sl 8-32x1/4	2	28	1536-034	Conv Tens Stud	1
10	UUAA304-2	Bearing, Bronze	1	29	3514-004	Roller Rubber	1
11	WWFF1/2	Felt Washer, 1/2	2	30	SSSC90032	Scr,So Cp 8-32x1/2	2
12	WWF8	Flat Washer, #8	2	31	SSSC01040	Scr,So Cp 1/4-20x5/8	2
13	1535-224	Shaft, Flatted	1	32	SSSC01096	Scr,So Cp 1/4-20x1 1/2	2
14	1535-229	Conv Left Side	1	33	SSSC20064	Scr,So Cp 5/16-24x1	1
15	1535-230	Guard, Conv Belt	2	34	350196	Gear Pulley	2
16	1535-231	Conveyor Spacer	2	35	350198	Pl Alignment	1
17	1535-241	Transfer Spacer	2	36	350199	Bracket Alignment	1
18	1535-248	Mount Transfer	1	37	3511AZ096M	Yoke, Roller	1
19	1535-250	Pl Transfer Side	1	AAC Drawing Number = 191044C Rev. 5			

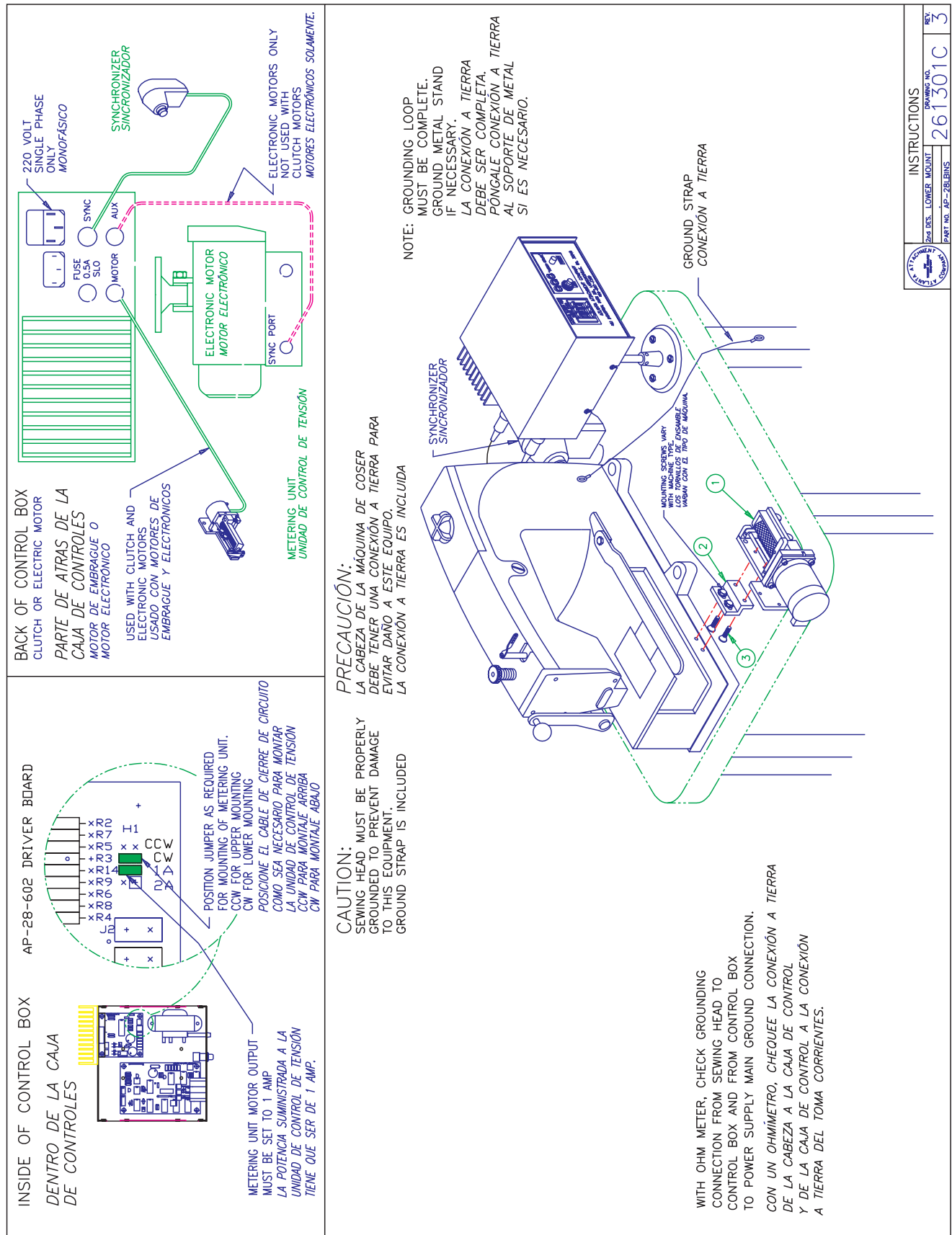


## 1536-066 Front Puller Assembly

See Pg. 35

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	350238	1		15	350199	1	
2	AAQME-5-8	2		16	3502-1072	1	
3	BBAW-3Z	1		17	3503	1	
4	CCCL6F	1		18	3503-1A	1	
5	IID016X128	1		19	3511A096B	1	
6	CCCL8F	1		20	3514	1	
7	SSSC20064	1		21	3517	3	
8	1325-12	1		22	WWFS10	1	
9	SSFS90016	2		23	SSTS85012	2	
10	NNJ5/16-24	1		24	WWF10	2	
11	WWFF1/2	2		25	NNK1/4-20	2	
12	SSSC98056	1		26	NNK10-32	2	
13	3513-1	1		27	SSSC01096	1	
14	350198	1		AAC Drawing Number - 191209C Rev. 1			

# Grounding Instructions For 11536A



INSTRUCTIONS		
264 DES. LOWER MOUNT	DRAWING NO.	REV.
PART NO. AP-28 BINS	261301C	3

Notes

# Notes



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